



24" SINGLE FACE PLANER
VARIABLE FEED RATE
30-460

**OPERATING
MAINTENANCE
INSTRUCTIONS**



FEATURES

- Cast-iron breaker system. Three "v" belts drive the cutterhead.
- Large control knob of variable speed feed system to increase or decrease speed when the planer is in operation.
- Metric and SAE graduation scale to indicate workpiece thickness on the front of the machine.
- The anti-kickback finger system at the front of the machine eliminates any risk of stock being forcibly ejected.
- A dust chute with its 6" outlet to receive a dust collector.
- Magnetic control with overload protection.

SPECIFICATIONS

TABLE SIZES

MAXIMUM PLANING WIDTH
MAXIMUM PLANING THICKNESS
MINIMUM PLANING THICKNESS
MINIMUM PLANING LENGTH
MAXIMUM PLANING DEPTH
CUTTERHEAD DIAMETER
KNIVES
CUTTERHEAD SPEED
FEEDING SPEED (VARIABLE)
CUTS PER INCH (25.4 mm)
MOTOR
WEIGHT

MODEL 30-460 / 30-460HC

25 1/4" x 28" (660 x 711 mm)
24" (610 mm)
8" (203 mm)
3/16" (4.75 mm)
8" (203 mm)
5/16" (8 mm)
3 1/8" (80 mm) / 3 5/16" (84 mm)
3 / HELICAL
4800 RPM
20 TO 38 FPM (6 TO 11.6 M/MIN)
62.5/20 FPM TO 33/38 FPM / —
10 HP, 220 V, 3 Ph
10 HP, 600 V, 3 Ph
1015 LBS (460 kg)

SAFETY RULES

READ CAREFULLY BEFORE OPERATING THE MACHINE

1. Learn the machine's applications and limitations, as well as the specific potential hazards particular to this machine. Follow available safety instructions and safety rules carefully.
2. Keep working area clean and be sure adequate lighting is available.
3. Do not wear loose clothing, gloves, bracelets, necklaces, or ornaments. Wear face, eye, ear, respiratory and body protection devices, as indicated for the operation or environment.
4. Keep hands well away from cutterhead and all moving parts. Do not clear chips and sawdust away with hands. Use a brush.
5. Make sure the cutters are moving at operation speed before planing.
6. Do not push the cutterhead to hard. The planer will perform better and be safer working at the rate for which it was designed.
7. Whenever possible use a dust collector with shaving hood to minimize health hazards.
8. Never leave the machine with the power on.
9. Never use a power feeder with the planer.
10. Keep children away. Make sure that visitors are kept at a safe distance from the work area.
11. Use recommended speed cutters accessory, and workpiece material.
12. Never stand on tool. Serious injury could occur if the tool is tipped or if the cutters are unintentionally contacted.
13. Be sure planer blades are securely locked in the machine.
14. Use suitable support if stock is too long.
15. Do not force the machine. It will do the job better and be safer at a rate for which it was designed.
16. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning make sure it is properly attached before using the tool again.
17. Be sure that key and adjusting wrenches have been removed before turning power on.
18. Use only accessories designed for the machine.
19. Make sure tool is properly grounded. If tool is equipped with three-prong plug, it should be plugged into a three-pole electrical receptacle. Never remove the third prong.
20. Always disconnect tool before servicing and when changing accessories such as planer blades.
21. Make sure that switch is in «OFF» position before plugging in cord.
22. Place material firmly against the table.
23. Use ONLY recommended accessories. Use of accessories NOT recommended by General International may result in a risk of injury.
24. Do not use this planer for other than its intended use. If used for other purposes, General International disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.

GENERAL ® INTERNATIONAL guarantee

All component parts of GENERAL INTERNATIONAL machinery are carefully inspected during all production stages and each machine is thoroughly inspected upon completion of assembly. Because of quality, GENERAL INTERNATIONAL agrees to repair or replace any genuine part or parts which, upon examination, proves to be defective in workmanship or material within a period of 24 months from date of purchase. In order to obtain warranty, all defective parts must be returned prepaid to GENERAL INTERNATIONAL MFG. Co Ltd. Repairs made without our written authorization voids all guarantees.

24» INDUSTRIAL PLANER

VARIABLE FEED SPEED

30-460

GENERAL® INTERNATIONAL industrial planers are carefully tested and inspected before shipment and if properly used will give perfect results. However, a reasonable amount of care and attention is necessary to ensure perfect performance and accurate work. It is imperative that you take a few moments to familiarise yourself with these instructions, as they will no doubt save you a lot of time and trouble.

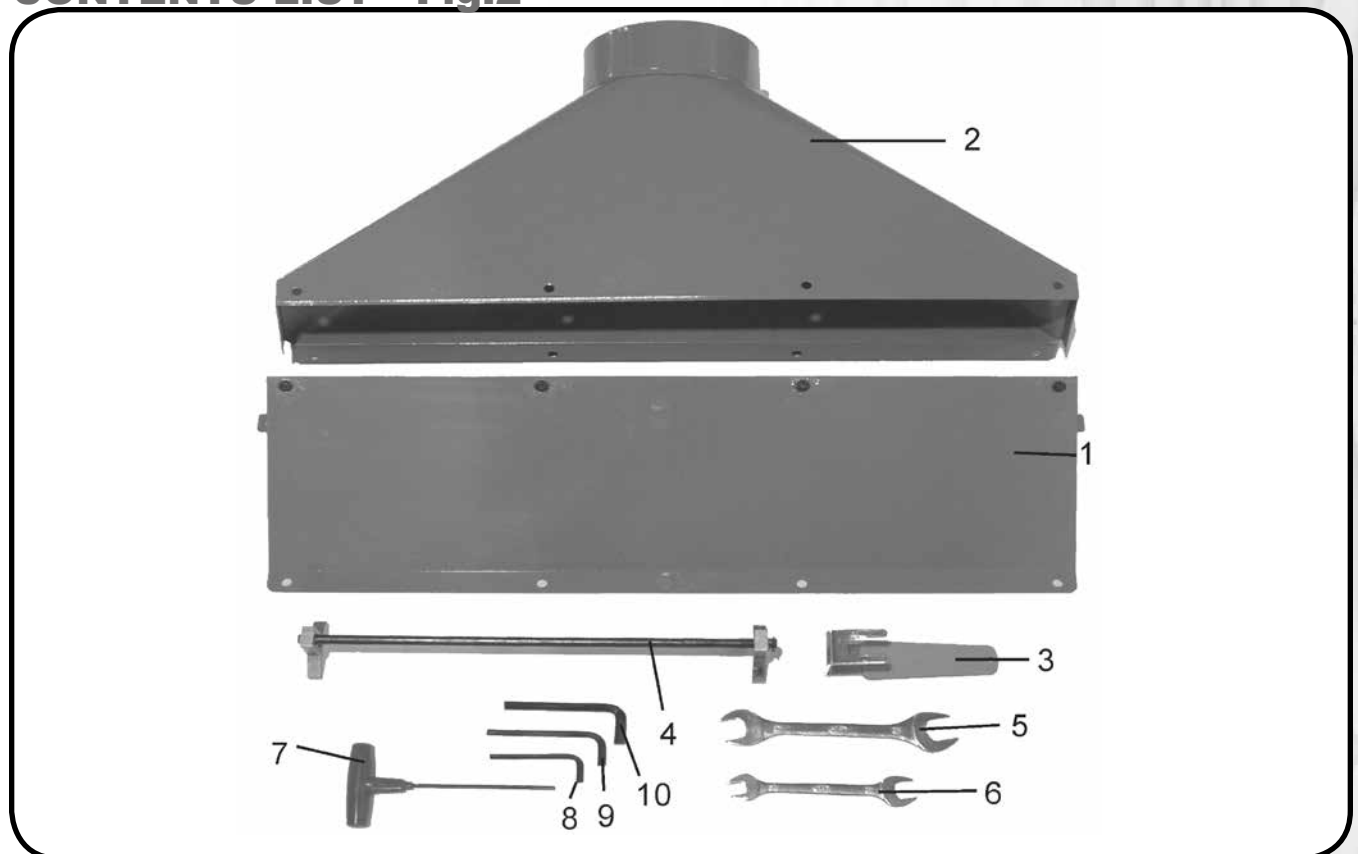


UNPACKING AND CLEANUP

To ensure maximum performance from your GENERAL® INTERNATIONAL 24» industrial planer 30-460, clean it properly; and install it accurately before use. As soon as you receive the planer, we recommend you follow these procedures:

1. The 24» planer is shipped in one container mounted to a shipping skid. Remove the wooden crate from around the machine. The planer is shipped with the motor, motor pulley and belts assembled to the machine.
2. Finish removing the contents of the shipping crate and compare with the contents list.(Fig.2)
3. Report damage, if any to your local distributor.
4. Clean all rust protected surfaces with a mild solvent or kerosene. Do not use lacquer thinner; paint thinner, or gasoline. These will damage painted surfaces.
5. To prevent rust, apply a light coating of paste wax to surface.9

CONTENTS LIST - Fig.2



- A. CUTTERHEAD GUARD
- B. DUST HOOD
- C. SAFETY HANDLE
- D. KNIFE SETTING GAUGE

- E. 12 X 14MM OPEN END WRENCH
- F. 10 X 8MM OPEN END WRENCH
- G. T-HANDLE WRENCH

- H. ALLEN WRENCH (4MM)
- I. ALLEN WRENCH (5MM)
- J. ALLEN WRENCH (6MM)

INSTALLATION

1. Remove the fastening bolts from the machine to the shipping skid.
2. Two lifting lugs are built into the machine, one of which is illustrated in (Fig.3,A). These lugs can be used to mechanically lift the machine using a forklift and lifting straps.

Note: The second lifting lug is located at the back opposite end of the machine.

3. Table can be lowered (Fig.3,B) to facilitate cleaning, loosen lock knob (C) and turn handwheel (D) counter-clockwise until the table (B) is at the desired height for cleaning.
4. Loosen and remove screw from the top edge of the machine (Fig.4,E). Raise the top cover as illustrated in (Fig.5,F) this step will expose the chipbreakers, and the cutterhead. Note: The top cover of the machine is hinged to facilitate cleaning and adjustment procedures
5. Carefully remove the protective coating from the table, table rolls, infeed roll, anti-kickback fingers, cutterhead and cutterhead knives. This protective coating may be removed with a soft cloth moistened with kerosene.
 - **Never attempt to use Gasoline, Acetone or Lacquer thinner, these products will damage any painted areas.**
 - **Caution: Extreme care should be taken when cleaning the knives, as the cutterhead knives are extremely sharp.**
6. After cleaning, cover the table surface with a layer of quality paste wax.
7. Lower top cover and replace locking screw that was removed in step 4.

ASSEMBLING HANDWHEEL HANDLE

Thread handle assembly (A) Fig.6 into handwheel (B) and tighten locknut (C).

ASSEMBLING CUTTERHEAD GUARD

Position the cutterhead guard (A) Fig.7, on the top cover of machine. Align holes in cutterhead guard with holes in top cover and fasten with (six) 6mm-button head screws (B) as illustrated in Fig.7

FIG. 3

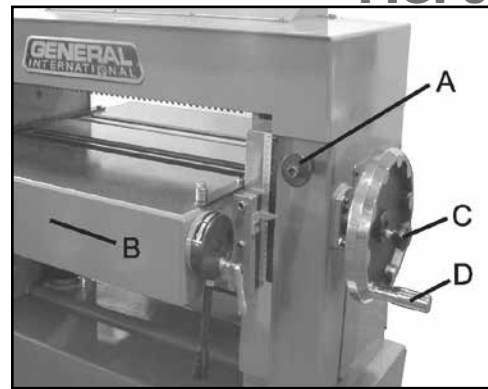


FIG. 4

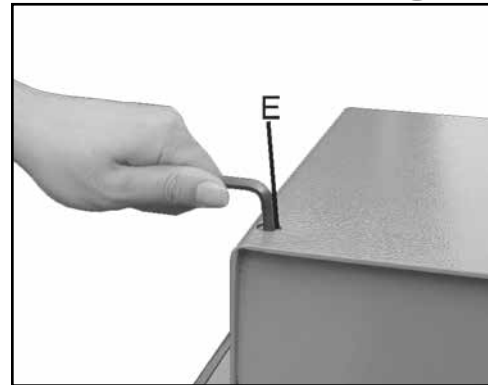


FIG. 5

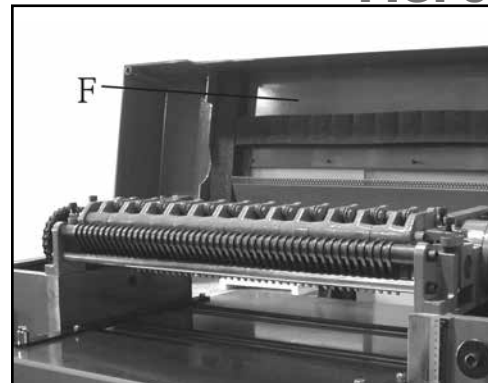


FIG. 6

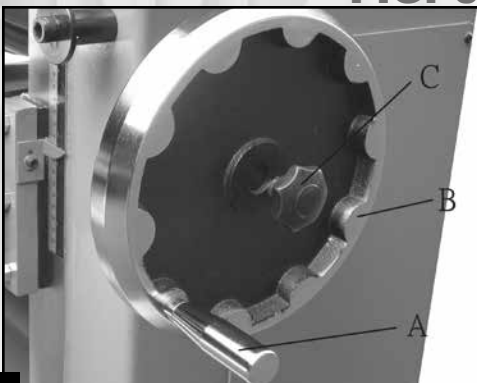


FIG. 7



ASSEMBLING DUST HOOD

A dust hood with a 5» opening is supplied with your machine and is to be used when connecting the planer to a dust collector or a central dust collection system.

Position dust hood (A) Fig.8, against the rear of the machine and on the top of cutterhead guard (B). Align the holes and fasten the dust hood (A) Fig.9, to the cutterhead guard (B) using eight 6mm-button head screws (C) as illustrated in Fig.9.

FIG. 8

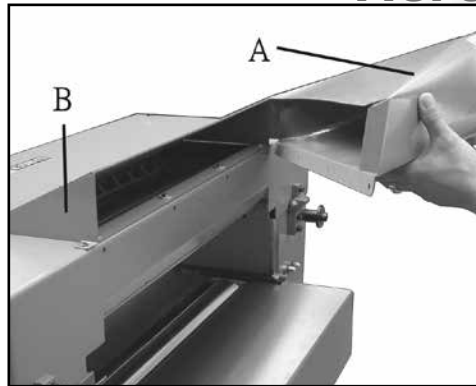
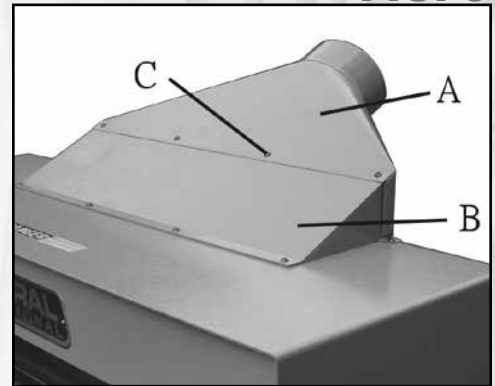


FIG. 9



..... **CAUTION!**
NEVER ATTEMPT TO CONNECT TO AN OUTLET WITH A GREATER POWER SOURCE VOLTAGE THAN REQUIRED!

..... **ATTENTION!**
ALWAYS VERIFY THAT THE MACHINE IS PROPERLY GROUNDED TO AVOID ELECTRIC SHOCK TO THE WORK OPERATOR!

ELECTRICAL CONNECTIONS & REQUIREMENTS

Before connecting the planer to the power source verify that the voltage supplied corresponds as specified on the nameplate of the machine. A power source with greater voltage than needed can result in serious injury to the user as well as damage the machine. If in doubt, contact a qualified electrician before connecting to the power source.

NOTE: Power cord and plug is not shipped with the planer. The standard machine shipped wired for 220/440 or 575 volt operation.

To wire the planer follow the following steps:

1. Loosen screw (A) Fig.10, and remove cover (B) from the terminal box located at the back of the machine. Bring the power line up through hole (C) Fig.11, in the terminal box. **NOTE: Strain relief and power cord clamps are not supplied with the machine. Remove the plastic shield (D) Fig.11, from terminal strip (E)**
2. Connect the three power lines to terminals F,G, & K Fig.12, along with the green ground wire to terminal H. After applying power to the machine, turn the power off to check if the machine is rotating correctly. If the cutterhead is not rotating correctly, interchange any two of the three power lines connected to terminals F,G & K.

FIG. 10

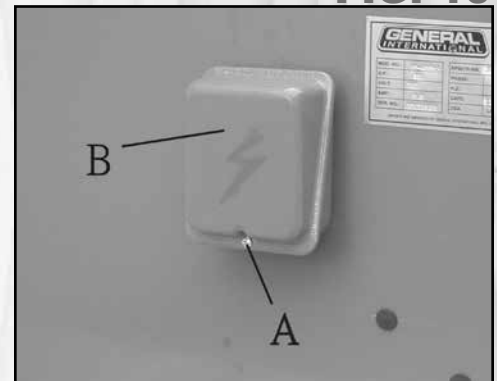


FIG. 11

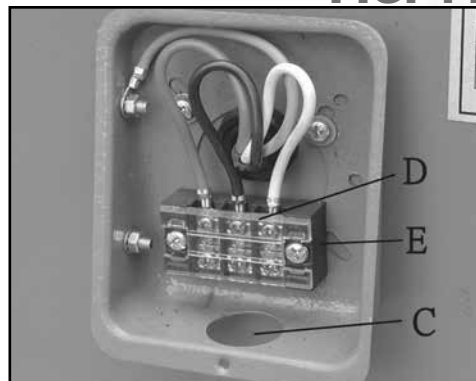
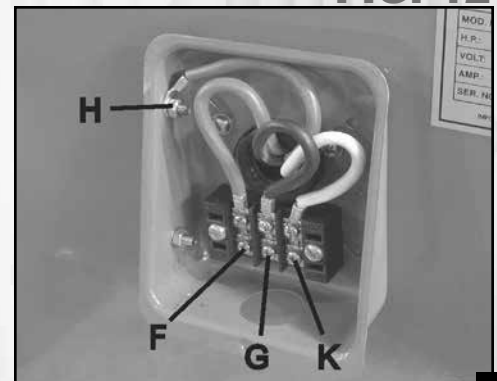


FIG. 12



CHANGING VOLTAGE

If you must reconnect your machine for 220 or 440-volt operation, please contact or have a certified electrician connect the machine to the power source.

GROUNDING

Machine must be properly grounded in order to avoid electric shock to the work operator. The use of an extension cord is not recommended, if necessary use a three-prong extension cord and outlet (immediately replace the extension cord if worn out, cut or damaged). If in doubt contact a qualified electrician.

OPERATING CONTROLS & ADJUSTMENTS

START / STOP SWITCH (Fig.13)

The power switch is located on the left side of the machine. Press the green button «On» to start the machine (A)

Press the red button «Off» to stop the machine (B)

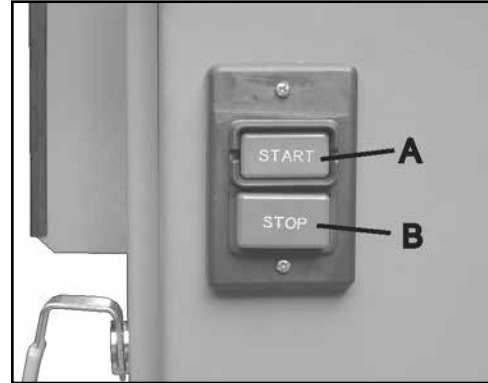


FIG. 14

LOCKING SWITCH IN THE «OFF» POSITION (Fig.14)

We suggest to padlock or use a pin to lock the start button (C) when machine is not in use, this will prevent unauthorized use and additional safety when the machine is turned «Off».

Insert a pin through the two holes in the start button as illustrated in Fig.14.



RAISING & LOWERING THE TABLE (Fig.15)

Adjustment to the table height can be made by loosening lock knob (A) and rotating the raising and lowering of table with handwheel (B).

To raise table: turn the handwheel (B) clockwise.

To lower table: turn the handwheel (B) counter-clockwise.

Tighten lock knob (A), after table height adjustment is made in order to lock in position.

The metric table height scale (C) will indicate the table height setting.

Note: For best results, setting of the table should always be made from the bottom to upward position.



FIG. 16

ADJUSTING FEED SPEED (Fig.16)

1. The feed speed for the planer is variables from 20 to 38.7 FPM.
2. Use the speed selector knob (A); in order to change the feed speed.
3. Turn the speed selector knob clockwise to decrease the feed speed. Turn counter-clockwise to increase feed speed.

Important: Never change the feed speed when machine is stopped; change the feed speed only while the machine is running.

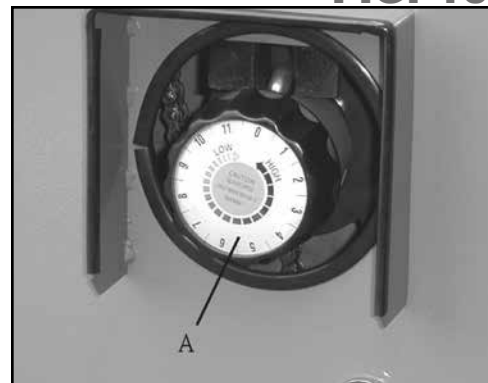


TABLE ROLLS (Fig.17)

The planer is equipped with two-table rolls (A); which aid in feeding the stock. This will reduce friction between the stock and the table and will rotate as the stock is fed through the planer.

1. To raise the table rolls, loosen lock lever (B) as illustrated in Fig.17 and pull control lever (C) upwards to the required height setting.
2. To lower the table rolls, loosen locking lever (B) and push the control lever (C) downwards to the required height setting.
3. After adjusting height of the table roll, tighten the lock lever (C) in order to lock in position.

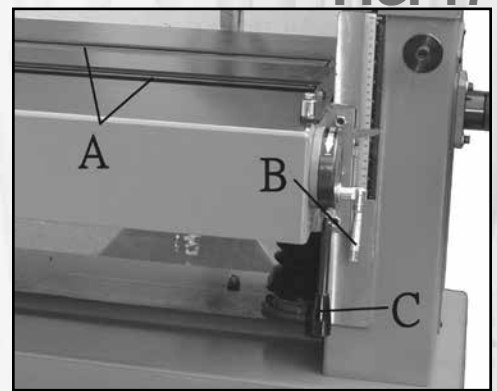


FIG. 17

CHECKING AND ADJUSTING TABLE ROLL HEIGHT

It is not possible to give the exact dimensions on the proper height setting of the table rolls because each type of wood has different behavioral patterns. As a general rule, when planing rough stock, the table rolls should be set high (.003» to .005») above the table surface. When planing finish stock, the table rolls should be set low (.001») above or level with the table surface.

To verify and adjust the height of the table rolls, proceed as follows:

1. Disconnect the machine from the power source.
2. With the table rolls in the lowest position, place a straight edge (A) Fig.18, across both table rolls (B) or the left side of the table as shown.
3. With a feeler gauge (B) Fig.19, measure the gap between the table surface and the straight edge (A) near the infeed roll (C).
4. If adjustment to the infeed table roll is necessary, loosen the locknut (D) Fig.20; located under the table and below the infeed roll and rotate adjustment nuts (E) as required to raise or lower the height of the infeed roll.

NOTE: it will be necessary to raise the table in order to gain access to the adjustment nuts. Tighten locknut (D) after adjustment is made.

5. Verify and adjust the height of the infeed table roll or the other side of the table in the same manner.
6. To check the height of the outfeed table roll, proceed as follows: with a feeler gauge (B) Fig.21, measure the gap between the table surface and the straight edge (a) near the outfeed roll(F).

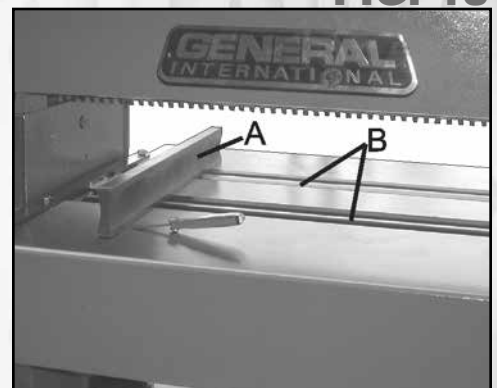


FIG. 18

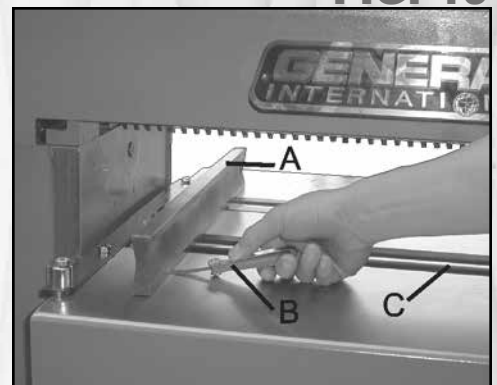


FIG. 19

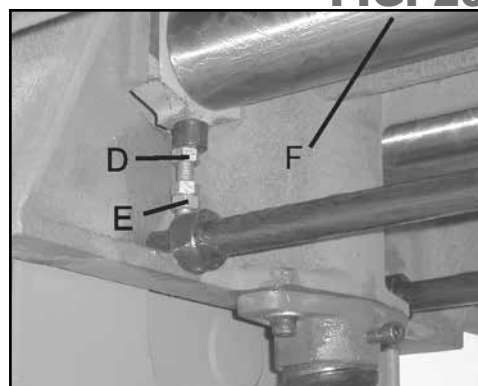


FIG. 20

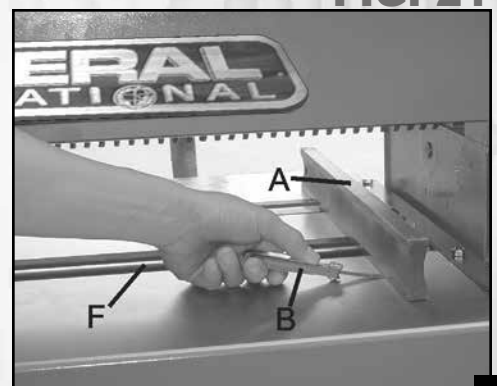


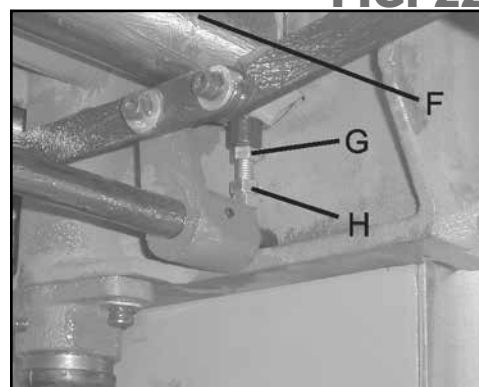
FIG. 21

7. If an adjustment to the outfeed table roll is necessary loosen locknut (G) Fig.22, located under the table below the outfeed table roll (F). Rotate the adjustment nuts (H) as required; in order to raise or lower the height of the outfeed roll (F).

NOTE: it will be necessary to raise the table in order to gain access to the adjustment nuts. Tighten locknut (G) once adjustments are completed.

8. Verify and adjust the height of the outfeed table roll on the other side of the table in the same manner.

FIG. 22

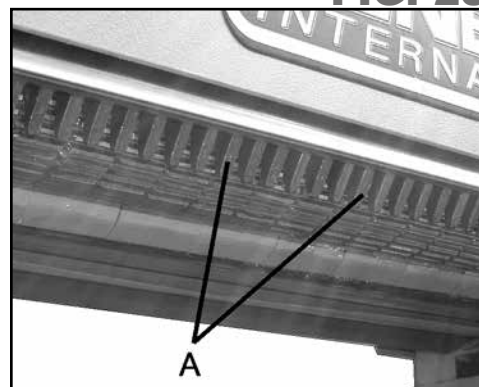


ANTI-KICKBACK FINGERS (FIG.23)

A series of anti-kickback fingers (A), are provided on the infeed end of the planer to prevent kickback of the workpiece during planing operations. These anti-kickback fingers operate by gravity and no adjustment is required. It is necessary, however to inspect them occasionally to make sure they are free of gum and pitch and that they are operated independently and freely.

WARNING: When inspecting or cleaning the anti-kickback fingers; make sure the machine is turned «OFF» and disconnected from the power source.

FIG. 23

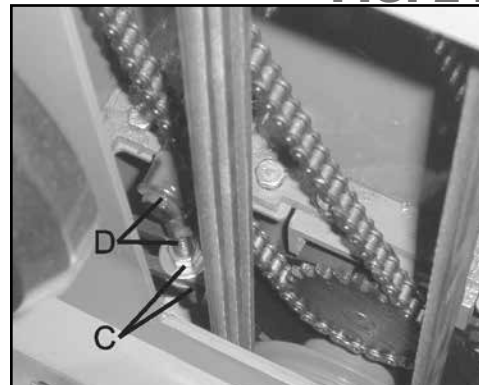


VERIFY AND ADJUST DRIVE BELT TENSION (FIG.24)

Proper belt tension is correct when there is approximately 1/4» deflection, using light finger pressure on the drive belts (A) Fig.24, midway between pulleys. If adjustments are required proceed as follows:

1. Disconnect the machine from the power source.
2. Loosen and tighten the two adjustment nuts (C), in order to move motor plate up or down as needed to increase or decrease the drive belt tension. Tighten both adjustment nuts (C) against plate (D) once adjustments are completed.
3. Close both side panels.

FIG. 24



..... CAUTION!

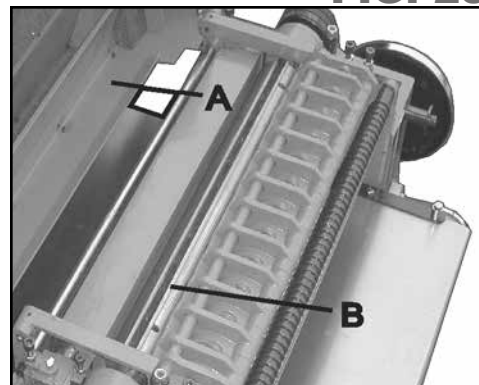
KNIVES ARE EXTREMELY SHARP, PLEASE PROCEED WITH CAUTION WHEN REPLACING OR REMOVING!

CHECKING, RESETTING AND REPLACING KNIVES

When checking, resetting and replacing knives, proceed as follows:

1. Disconnect the machine from the power source.
2. Remove the locking screw and raise top cover (A) Fig.25, to reveal cutterhead (B)
3. Carefully place knife setting gauge (C) Fig.26 & 27, in order to position the gauge on the radius section of the cutterhead (B). When set correctly, knife (D) Fig.26 & 27, should slightly contact the bottom of the insert section(E) Fig.27 of knife gauge (C) which is set at .070». Verify the remaining knives in the same manner.

FIG. 25



4. If an adjustment to one or all three knives is necessary, slightly loosen the 12 locking screws, 10 of which are shown in Fig.26 & Fig.27 (F) loosen just enough to relieve stress in the cutterhead (B) and do not disturb the knife setting.

5. With the knife setting gauge (C) Fig.26 & 27 still in place on the cutterhead, continue to adjust the knife that must be reset by turning the 12 knife locking screws CLOCKWISE until knife locking bar (G) becomes loose. The lifter springs and screws (not shown) located under the knife will automatically raise the knife until it comes in contact with the gauge (C). Then tighten up the knife locking bar (G) Fig.26 & Fig.27, by turning the ten screws (F) COUNTER - CLOCKWISE.

IMPORTANT: At this time, only tighten the knife locking bar (G) just enough to hold the knife (D) in position inside the cutterhead slot.

6. If other knives need adjustment, repeat step 5.

7. After all the knives are positioned in the cutterhead with the knife locking screws tighten and , turn each of the 12 locking screws (F) Fig.26, COUNTER-CLOCKWISE until the knives are secure in the cutterhead.

IMPORTANT: If the knives are to be removed for sharpening or replacement, extreme caution must be taken as the knives are very sharp and dangerous.

To remove: Knives proceed as follows:

8. Disconnect the machine from the power source .

9. Carefully place knife setting gauge (C) Fig.26, in order to position the gauge on the radius section of the cutterhead (B) Fig.27.

10. Loosen the knife locking bar (G) Fig.26 & Fig.27, by turning the 12 knife locking screws; 10 of which are shown in (F). Turn the screws CLOCKWISE and carefully remove the locking bar (G) and knife (D) along with the springs and screws located under the knife from the cutterhead (not shown) . Remove the remaining knives in the same manner.

11. Thoroughly clean the knife slots, knife locking bars, and locking screws. Verify the screws; if the threads appear worn or stripped, or if the heads are damaged replace immediately.

12. Carefully replace the springs and screws (not shown) knives (D) Fig.27, and the knife locking bars (G) into the three slots in the cutterhead (B).

IMPORTANT: When replacing the knife locking bars (G) Fig.27 against knives (D) as illustrated in the cross section diagram. Be sure that the knife locking bars (G) are installed as shown, with the locking screws (F) holding knives (D) properly inside the cutterhead slots. Turn all knife locking screws(F), COUNTER-CLOCKWISE just enough to hold the knives in the cutterhead.

13. Adjust the knives as explained in Step 3 through 7.

14. Replace the top cover on the machine.

FIG. 26

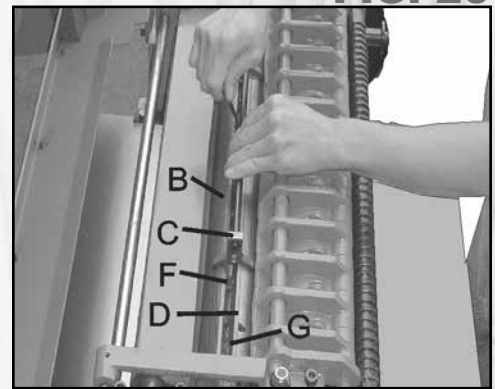


FIG. 27

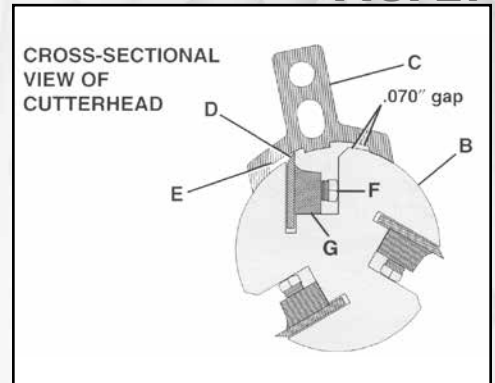
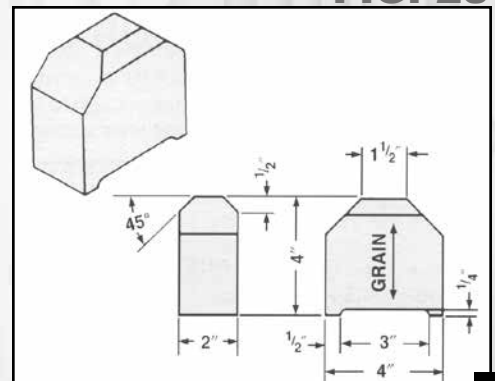


FIG. 28



CHECKING, RESETTNG AND REPLACING KNIVES

In order to check and adjust the height of the chipbreaker , pressure bar, infeed and outfeed rolls and adjust the cutterhead parallel to the table, you will need a gauge block made of hard wood. The gauge block can easily be constructed by following the dimensions illustrated to you in Fig.28.

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ADJUSTING CHIPBREAKERS

The chipbreakers (A) Fig.29, are located on the top of the planer and extend downward around the front of the cutterhead. The chipbreakers will raise as stock is fed through the planer and «breaks or cuds» the wood chips. The bottom of the chipbreakers must be parallel to the knives and set .40» below the cutting circle. To check and adjust the chipbreakers, proceed as follows:

1. Disconnect the machine from the power source.
2. Make certain the knives are adjusted properly as explained in section «Checking, Replacing and Resetting Knives».
3. Place the gauge block (B) Fig.30, on the table surface and directly under the cutterhead as illustrated. Using a .040» feeler gauge (C) Fig.30, position on top of the gauge block, raise the table until cutterhead knife (D) touches the feeler gauge when the knife is at its lowest point.

NOTE: Do not move the table any further until the adjustment has been completed.

4. Move gauge block (B) Fig.31, directly under the chipbreaker (A) as illustrated. The bottom of the chipbreakers (A) Fig.31, should slightly touch the gauge block (B).
5. If an adjustment to the chipbreaker is necessary, loosen the two hex nuts (E) Fig.29, and turn the adjustment screws (F) until the chipbreaker slightly touches the gauge block at both sides of the table.

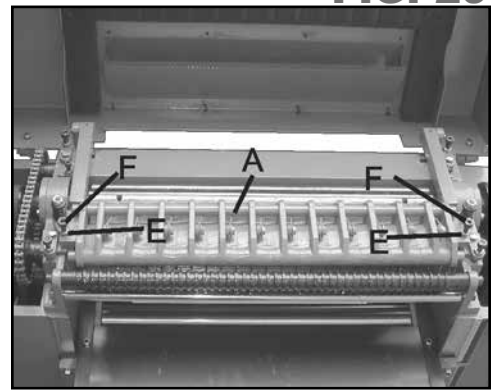


FIG. 29

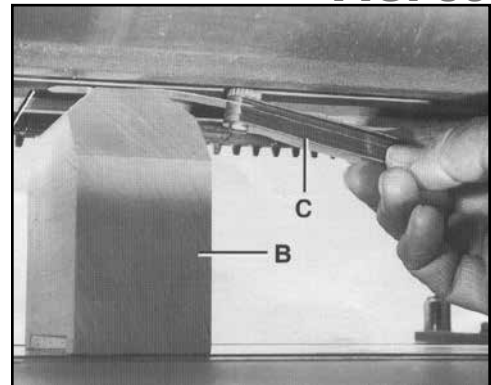


FIG. 30

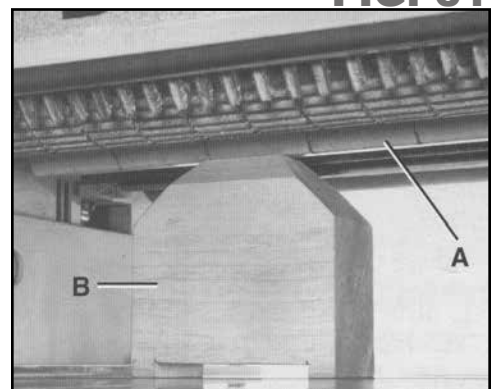


FIG. 31

ADJUSTING PRESSURE BAR

The pressure bar is located directly behind the cutterhead and rides on the planed surface of the stock, pressing the stock downwards on the table. The pressure bar must be parallel to the knives and in contact to the table and set .010» below the cutting circle. To verify and adjust the pressure bar, proceed as follows:

1. Disconnect the machine from the power source.
2. Verify that the knives are adjusted properly as explained in section «Checking, Adjusting and Replacing Knives».
3. Position the gauge block (B) Fig.32, on the table surface directly under the cutterhead as illustrated. Use a .010» feeler gauge (C) Fig.32, place on the top of the gauge block, raise the table until the cutterhead knife (D) touches the feeler gauge when the knife is at its lowest point. Do not move the table any further until the adjustment has been completed.
4. Move gauge block (B) Fig.33, under the pressure bar (D) as illustrated. The bottom of the pressure bar (D) Fig.33 should slightly touch the top of the gauge block (B). Verify the opposite end of the pressure bar in the same manner.
5. If an adjustment to the height of the pressure bar is necessary; loosen lock nut (E) Fig.34, and turn adjustment screw (F) until the bottom of the pressure bar (D) Fig.33 slightly touches the top of the gauge block (B). Repeat the adjustment at the other end of the pressure bar in the same manner.

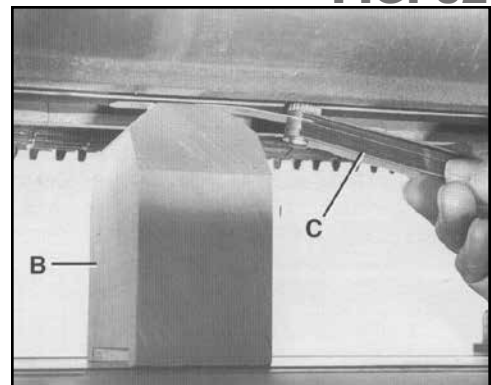
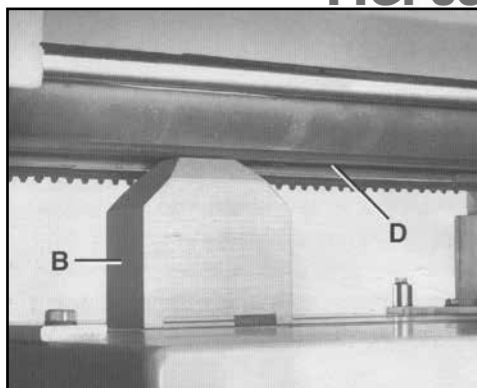
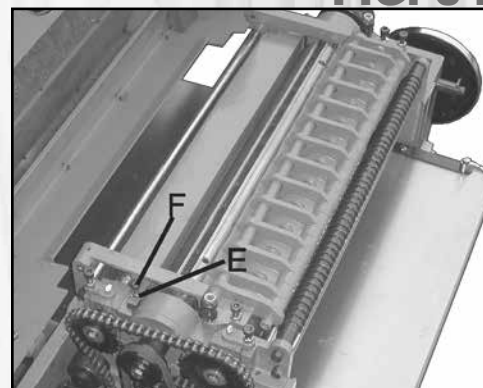


FIG. 32

FIG. 33**FIG. 34**

ADJUSTING OUTFEED ROLL

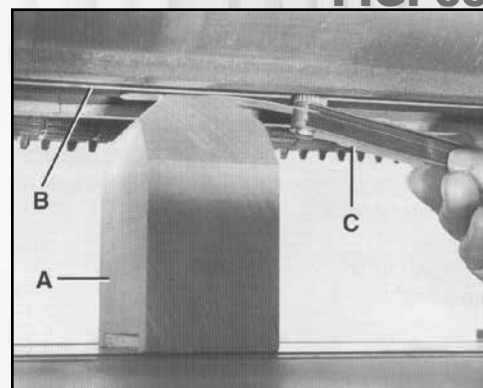
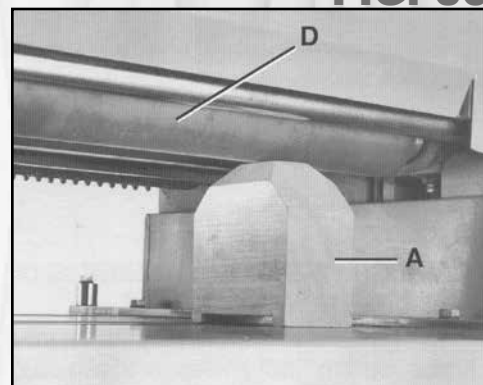
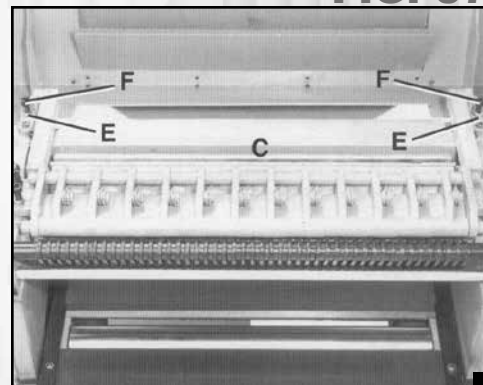
The outfeed roll continues to feed the stock out of the machine after the planing operation is completed and should be set at .030" below the cutting circle.

To check and adjust the setting of the outfeed roll, proceed with the following:

1. Disconnect the machine from the power source.
2. Verify that the knives are adjusted properly as explained in «Checking, Adjusting and Replacing Knives».
3. Place the gauge block (A) Fig.35 on the table, directly under the cutterhead (B). Using a .030" feeler gauge (C) place on the top of the gauge block (A), raise the table until the cutterhead knife slightly touches the feeler gauge (A) when the knife is at its lowest point.

NOTE: Do not move the table any further until the adjustment is complete.

4. Place the gauge block (A) Fig.36, under the outfeed roll (D). The bottom of the roll (D) should slightly touch the gauge block (A).
5. If an adjustment is necessary, loosen locknut (E) Fig.37 and turn adjustment screw (F) until the outfeed roller slightly touches the top of the gauge block (A) Fig.36.
6. Repeat the adjustment on the opposite end of the outfeed roll in the same manner.
7. Tighten locknuts (E) Fig.37 after adjustments are completed.

FIG. 35**FIG. 36****FIG. 37**

ADJUSTING INFEE ROLL

The infeed roll feeds the stock into the planer while the stock is being surfaced. The infeed roll must be positioned uniformly across the planer and .040" below the cutting circle of the feed stock without slipping.

To check the setting of the infeed roll, proceed with the following steps:

1. Disconnect the machine from the power source.
2. Check that the knives are adjusted properly as explained in section «Checking, Adjusting and Replacing Knives».

3. Place the gauge block (A) Fig.38 on the table, directly under the cutterhead (B). Use a .040» feeler gauge (C) and place on top of the gauge block (A), raise the table until the cutterhead knife slightly touches the feeler gauge (A) when the knife is at its lowest point. Note: Do not remove the table any further until the adjustment is complete.
4. Place the gauge block (A) Fig.39, under infeed roll (D). The bottom of the roller (D) should slightly touch gauge block (A).
5. If adjustments are necessary, loosen locknut (E) Fig.40, and turn adjustment screw (F) until the infeed roll slightly touches the top of the gauge block (A).
6. Repeat the adjustments on the opposite end of the infeed roller in the same manner.
7. Tighten locknuts (E) Fig.40, after adjustments are completed.

FIG. 38

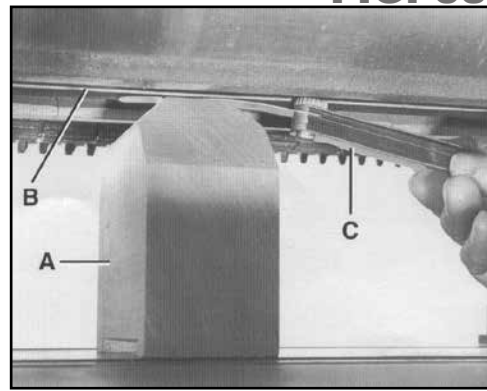


FIG. 39

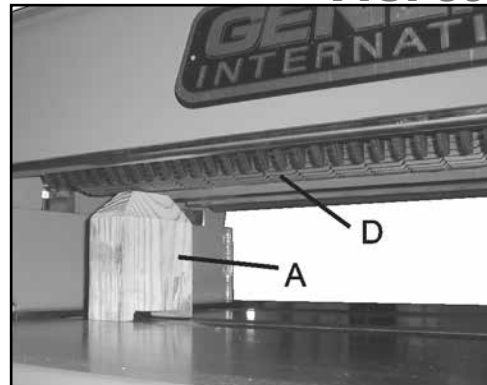
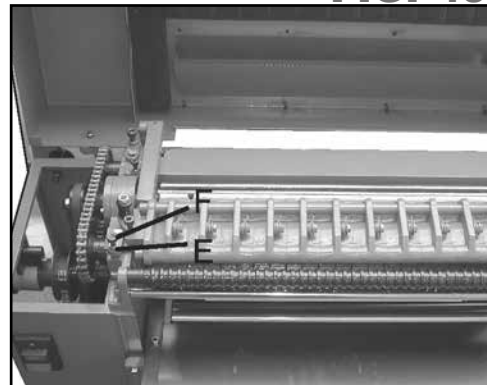


FIG. 40



LEVELLING THE TABLE

The table is set parallel to the cutterhead at the factory and no further adjustment should be necessary.

To check if the table is level with the cutterhead, proceed with the following steps:

1. Disconnect the machine from the power source.
2. Check if the cutterhead knives are correctly set as explained in «Checking, Adjusting and Replacing Knives».
3. Verify that the table is set parallel to the cutterhead by placing a gauge block (A) Fig.41 directly under the cutterhead on the left hand side of the table as illustrated. Raise the table until the gauge block (A) Fig.41, slightly touches the cutterhead.
4. Carefully move the gauge block (A) Fig.42, to the right hand side of the table directly under the cutterhead. The distance from the table to the cutterhead should be identical.
5. If the table is not parallel to the cutterhead, lower boot (B) Fig.43, which is located underneath the table. *NOTE: Table elevating hand-wheel must be unlocked when making this adjustment.*
6. Loosen lock screw (C) Fig.43, and with large pliers (D) turn adjustment sleeve (E) as required until table is parallel with the cutterhead. Tighten lock screw (C) after adjustment is completed and replace boot (B).

NOTE: The same adjustment can also be made on the other side of the planer if necessary.

Ã

FIG. 41



FIG. 42



ADJUSTING TABLE HEIGHT SCALE

The table height scale indicates the distance the table is from the cutting circle (depth of cut). To verify and adjust the pointer, proceed with the following steps:

1. Run a piece of wood through the planer and stop the machine.
2. Measure the thickness of the planed end of the stock as illustrated in Fig.44. If adjustment is required, loosen screw (A) Fig.45, adjust pointer (B) and re-tighten screw (A).

ADJUSTING TABLE GIBS

In the unlikely event of the table developing unwanted movement during planing operations, the table can be checked and adjusted by following these steps:

1. With the table in the locked position, and a feeler gauge; measure the gap between table gib (A) Fig.46 and table bracket (B). When set properly the gap should be .005»
2. If adjustment is required, loosen the three locknuts (C), and turn three adjustment screws (D) Fig.46, as necessary to set the correct gap.
3. Check and adjust the gap on the other side of the table in the same manner. After adjustments are completed, tighten the six locknuts, three of which are illustrated in (C) Fig.46.
4. Raise and lower the table to its fullest range and check to see if the table moves up and down without binding.

FIG. 43

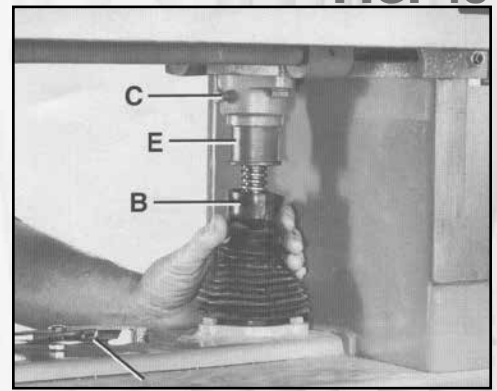


FIG. 44

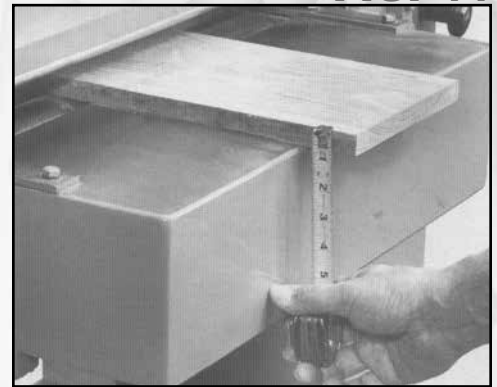


FIG. 45

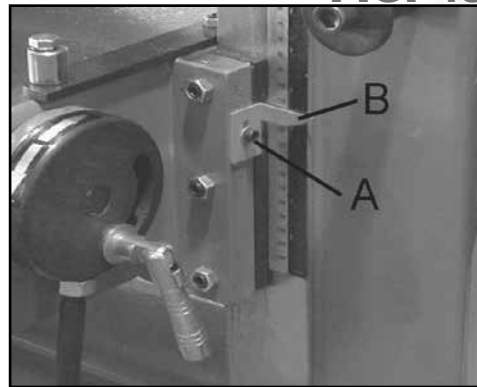
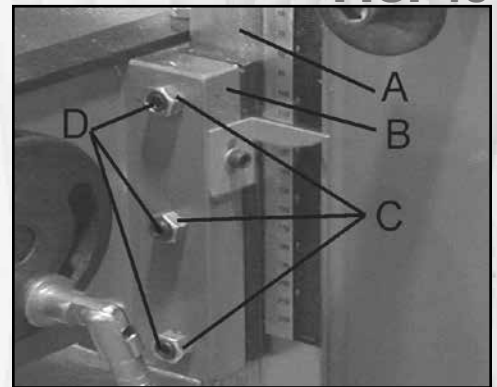


FIG. 46

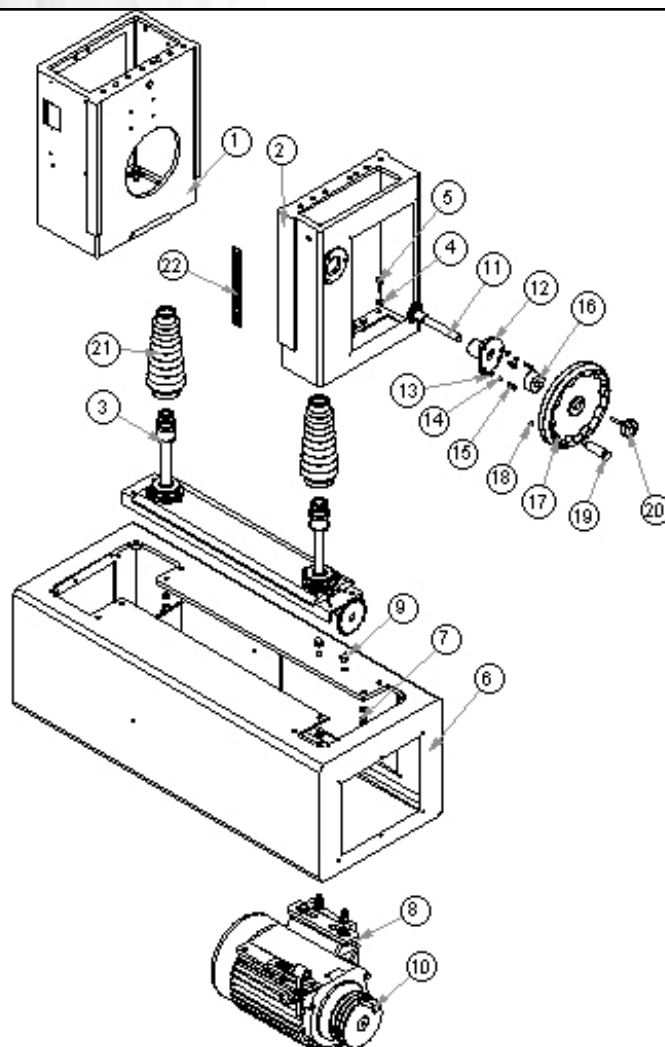


MAINTENANCE

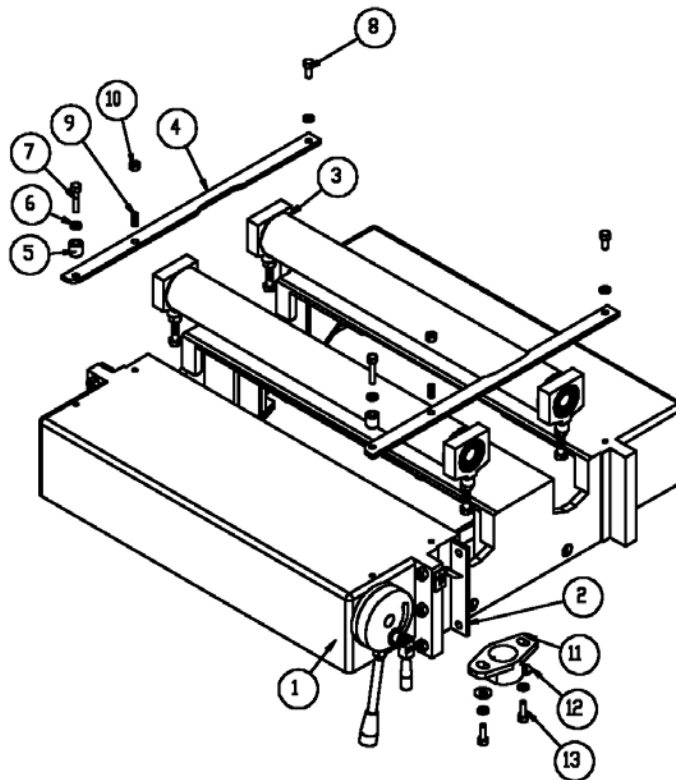
- Disconnect the machine from the power source.
- Planer knives must be sharpened when use after numerous projects.
- Periodic lubrication should be performed with grease or machine oil to assure the durability and accuracy of the use of machine.
- Always dust off dirt, chips, or any other particles left behind after operations have been completed.

PARTS LIST **30-460**

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-A01	C003016	(L) COLUMN BASE		1
30460-A02	C003017	(R) COLUMN BASE		1
30460-A03	G002008	ELEVATING SCREW		1
30460-A04	S284008	SPRING WASHER	10.2 x 18.8 x 3.9 x 3.0T	28
30460-A05	S137005	SCREW	M10-P1.5 x 30L	16
30460-A06	C002024	BASE		1
30460-A07	S273042	NUT	M10-P1.5	12
30460-A08	T004034	MOTOR ASS'Y	M12-P1.75	1
30460-A09	S277006	NUT		2
30460-A10	C034031	SHAFT		1
30460-A11	C067064	SPROCKET SHAFT		1
30460-A12	C015017	HUB		1
30460-A13	S282009	WASHER	6.4 x 13 x 1.0T	3
30460-A14	S274006	SPRING WASHER	6.1 x 12.2 x 2.7 x 1.5T	3
30460-A15	S201006	SCREW	M6-P1.0 x 25L	3
30460-A16	C051080	BUSHING		1
30460-A17	P026003	HANDWHEEL		1
30460-A18	S213014	SET SCREW	M8-P1.25 x 10L	1
30460-A19	P031001	HANDLE	5/16" x 2" L	1
30460-A20	P031006	KNOB	3/8" x 90L	1
30460-A21	C078003	BOOT		2
30460-A22	C081004	DEPTH SCALE		1

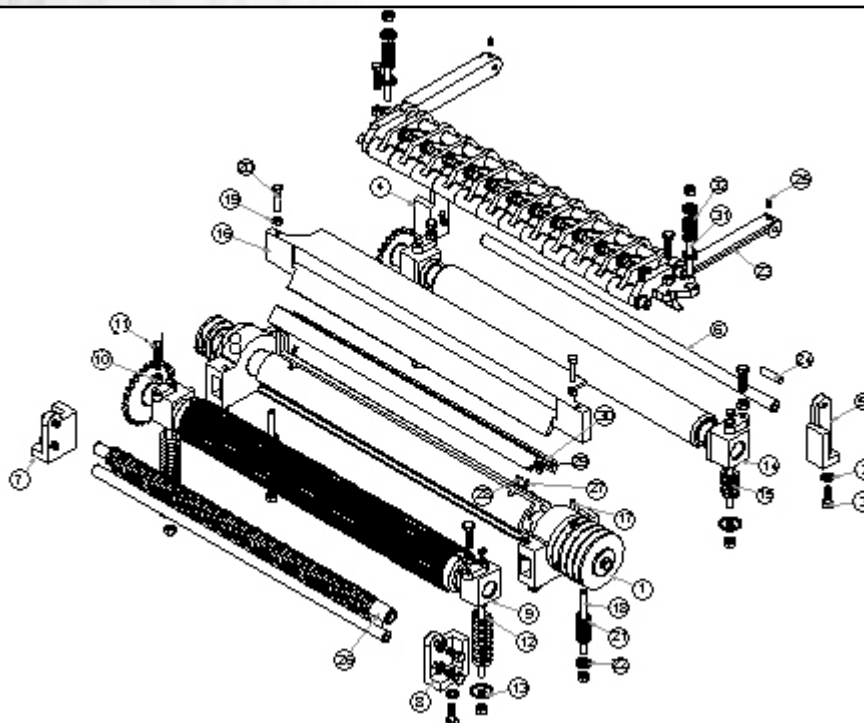


PARTS LIST

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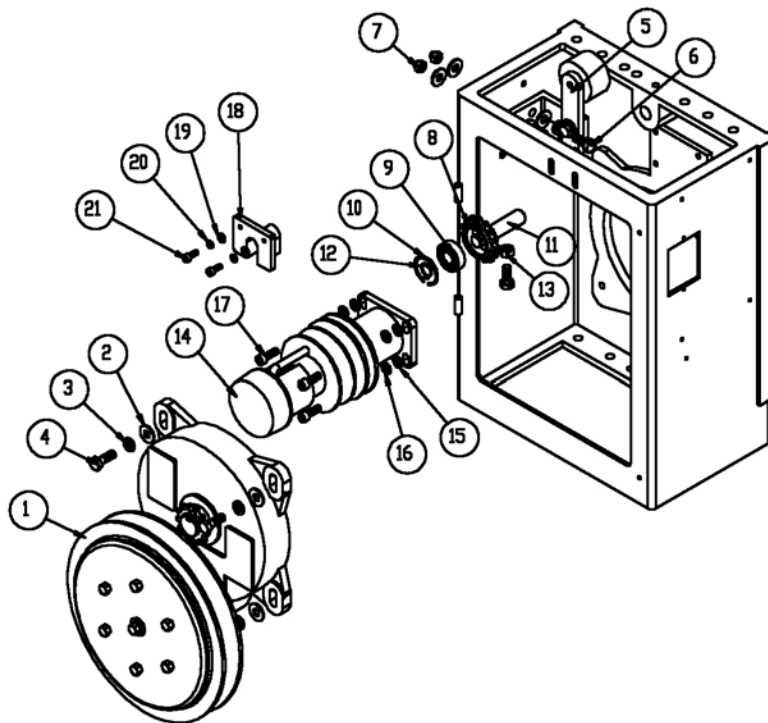
PARTS LIST **30-460**

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-C01	T001034	CUTTERHEAD ASS'Y		1
30460-C02	S284008	SPRING WASHER	10.2 x 18.4 x 3.7 x 2.5T	14
30460-C03	S203006	SCREW	M10-P1.5 x 30L	16
30460-C04	C015029	BRACKET (L)		1
30460-C05	C015096	BRACKET (R)		1
30460-C06	C046073	SHAFT	19.05 x 678L	2
30460-C07	C015032	BRACKET (L)		1
30460-C08	C015097	BRACKET (R)		1
30460-C09	T010015	INFEED ROLLER ASS'Y		1
30460-C10	S273042	NUT	M10-P1.5	14
30460-C11	S203008	SCREW	M10-P1.5 x 40L	4
30460-C12	C060007	SPRING WASHER		2
30460-C13	C053022	SPECIAL WASHER		4
30460-C14	T011007	BEARING BLOCK		1
30460-C15	C060012	SPRING		2
30460-C16	C042035	PRESSURE BAR		1
30460-C17	C046055	SCREW	6.35 x 62L	2
30460-C18	C034023	STUD (125mm)	M10-P1.5 x 125L	2
30460-C19	S273041	NUT	M8-P1.25	2
30460-C20	S202009	SCREW	M8-P1.25 x 40L	2
30460-C21	C060009	SPRING		2
30460-C22	C053023	SPECIAL WASHER		6
30460-C23	T009032	CHIPBREAKER ASS'Y		1
30460-C24	C046016	PIN	3/8" x 45L	2
30460-C25	S213014	SET SCREW	M8-P1.25 x 10L	2
30460-C26	T009034	ANTI-KICKBACK ASS'Y		1
30460-C27	C060014	SPRING		6
30460-C28	S246004	SCREW	M5-P0.8 x 16L	6
30460-C29	P054010	KNIFE	24"	3
30460-C30	O056011	LOCKING BAR	24"	3
30460-C31	C034021	STUD	M10-P1.5 x 90L	2
30460-C32	C060040	SPRING		2



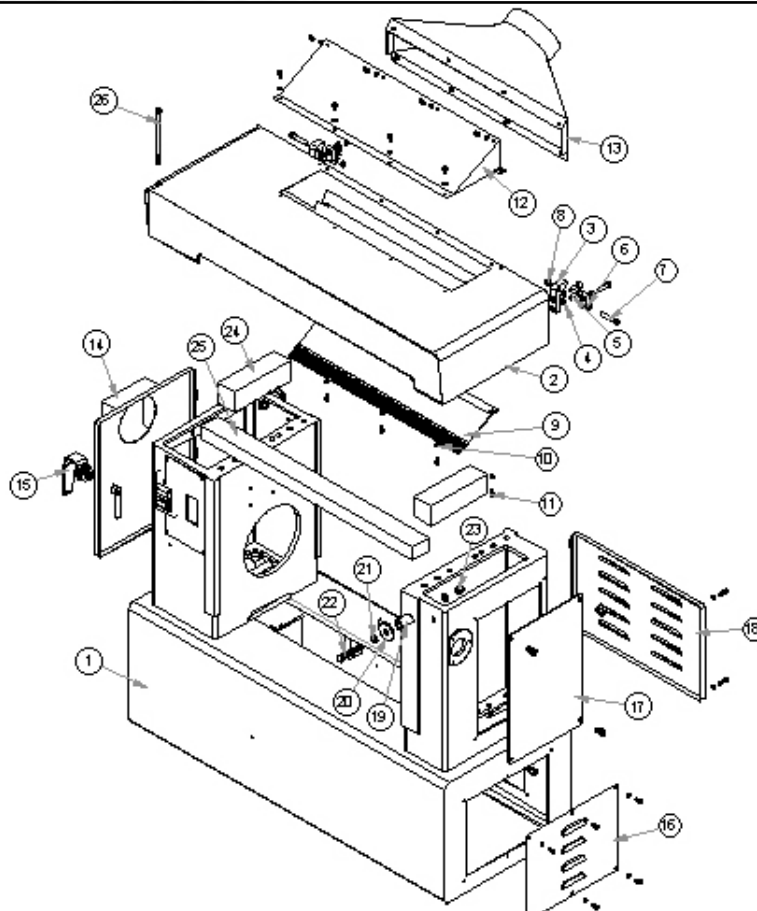
PARTS LIST 30-460

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-D01	G006011	GEAR BOX ASS'Y		1
30460-D02	S282011	WASHER	10.5 x 25 x 2T	8
30460-D03	S284008	SPRING WASHER	10.2 x 18.4 x 3.7 x 2.5T	6
30460-D04	S137005	SCREW	M10-P1.5 x 30L	4
30460-D05	T017006	LINK ASS'Y		1
30460-D06	S137004	SCREW	M10-P1.5x 25L	3
30460-D07	S277005	NUT	M10-P1.5	2
30460-D08	C067017	CHAIN GEAR		1
30460-D09	S026126	BALL BEARING	6203ZZ 17 x 40 x 12	1
30460-D10	S298074	RETAINING RING	40 x 1.95	1
30460-D11	C039004	SHAFT		1
30460-D12	S298008	EXT. RETAINING RING	17 x 1.15	1
30460-D13	S293043	NUT	M12-P1.75	1
30460-D14	T004035	VARIABLE FEED PULLEY ASS'Y		1
30460-D15	S282010	WASHER	8.4 x 16 x 1.5T	4
30460-D16	S284007	SPRING WASHER	8.2 x 15.4 x 3.2 x 2.0T	4
30460-D17	S202006	SCREW	M8-P1.25 x 25L	4
30460-D18	C023069	SUPPORT		1
30460-D19	S282009	WASHER	6.4 x 13 x 1.0T	2
30460-D20	S284006	SPRING WASHER	6.1 x 12.2 x 2.7 x 1.5T	2
30460-D21	S201004	SCREW	M6-P1.0 x 16L	2

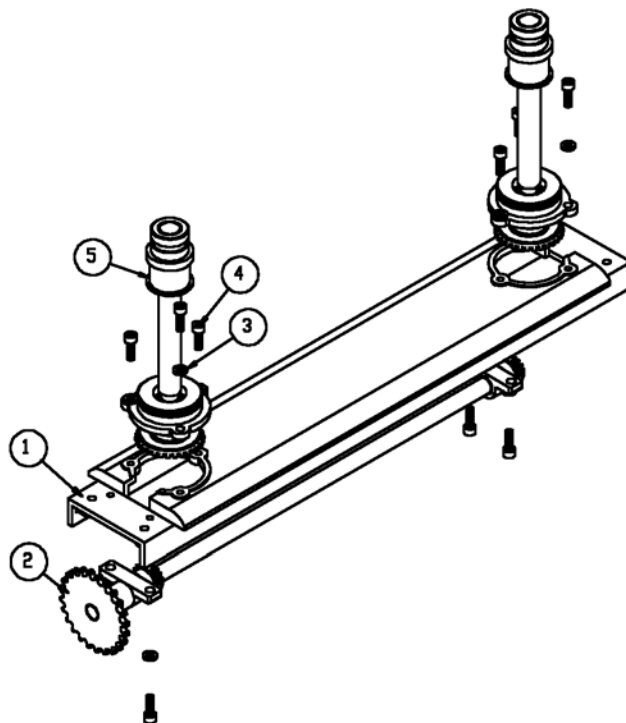


PARTS LIST **30-460**

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-E01	T020038	BASE		
30460-E02	C073079	TOP COVER		1
30460-E03	C061001	TOP COVER BRACKET		2
30460-E04	S284014	SPRING WASHER	8.5 x 15.6 x 3.2 x 2.5T	4
30460-E05	S136005	SCREW	M8-P1.25 x 30 L	4
30460-E06	C061002	HINGE		2
30460-E07	S136008	SCREW	M8-P1.25x50L	2
30460-E08	S273041	NUT	M8-P1.25	2
30460-E09	C078011	CHIP DISCHARGE COVER		1
30460-E10	S284006	SPRING WASHER	6.1 x 12.2 x 2.7 x 1.5T	38
30460-E11	S201011	LOCKING SCREW	M6-P1.0 x 45L	38
30460-E12	C023051	DUST CHUTE		1
30460-E13	C077024	DUST HOOD		1
30460-E14	C073082	(L) COVER		
30460-E15	P027003	SAFETY HANDLE		1
30460-E16	C073010	(R) BASE COVER		2
30460-E17	C073017	(R) COVER		1
30460-E18	C074214	REAR COVER		1
30460-E19	C039005	BUSHING		2
30460-E20	C053021	WASHER		2
30460-E21	S284009	SPRING WASHER	12.2 x 21.5 x 4.2 x 3.0T	4
30460-E22	S138009	SCREW		2
30460-E23	S273043	NUT		2
30460-E24	S326003	BAFFLE SEAL		2
30460-E25	S3216009	SEAL		1
30460-E26	S202019	STUD	160mm	1

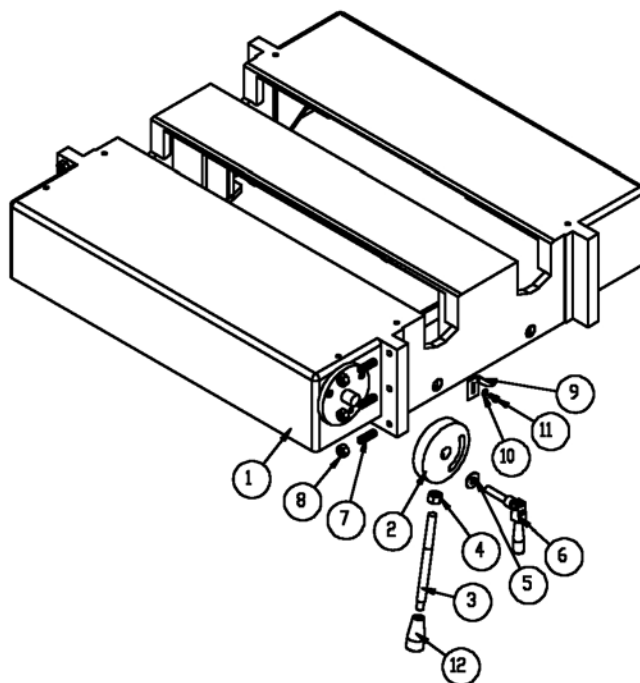


PARTS LIST

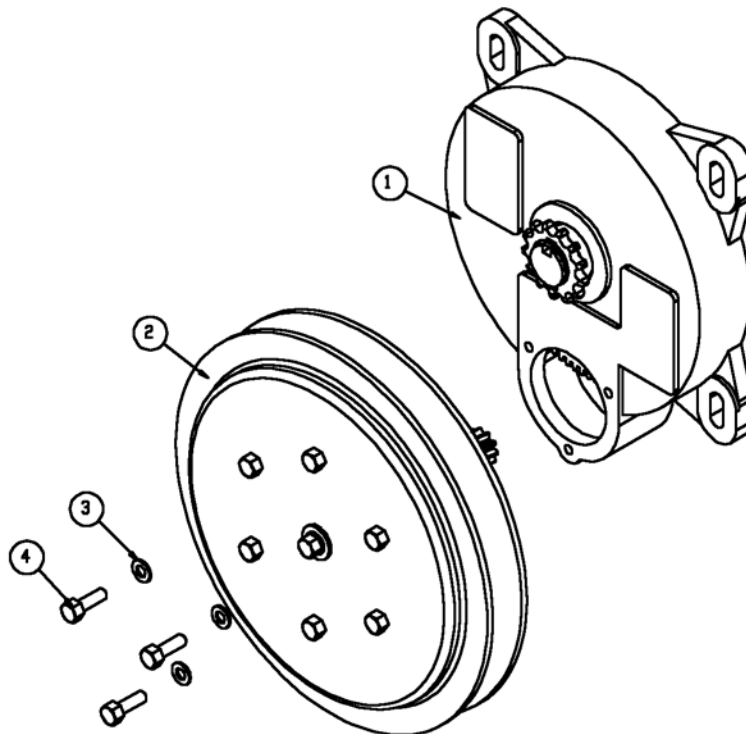
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PARTS LIST **30-460**

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-G01	T012029	TABLE WHEEL		1
30460-G02	C017014	HUB		1
30460-G03	C057006	LEVER		1
30460-G04	S273043	NUT	M12-P1.75	1
30460-G05	S282011	WASHER	10.5 x 25 x 2.0T	1
30460-G06	P028001	LOCK LEVER		1
30460-G07	S214006	SET SCREW	M10-P1.5 x 30L	6
30460-G08	S273042	NUT	M10-P1.5	6
30460-G09	C070003	POINTER		1
30460-G10	S282008	WASHER	5.3 x 10 x 1T	1
30460-G11	S202002	SCREW	M5-P0.8 x 10L	1
30460-G12	P031004	KNOB		1

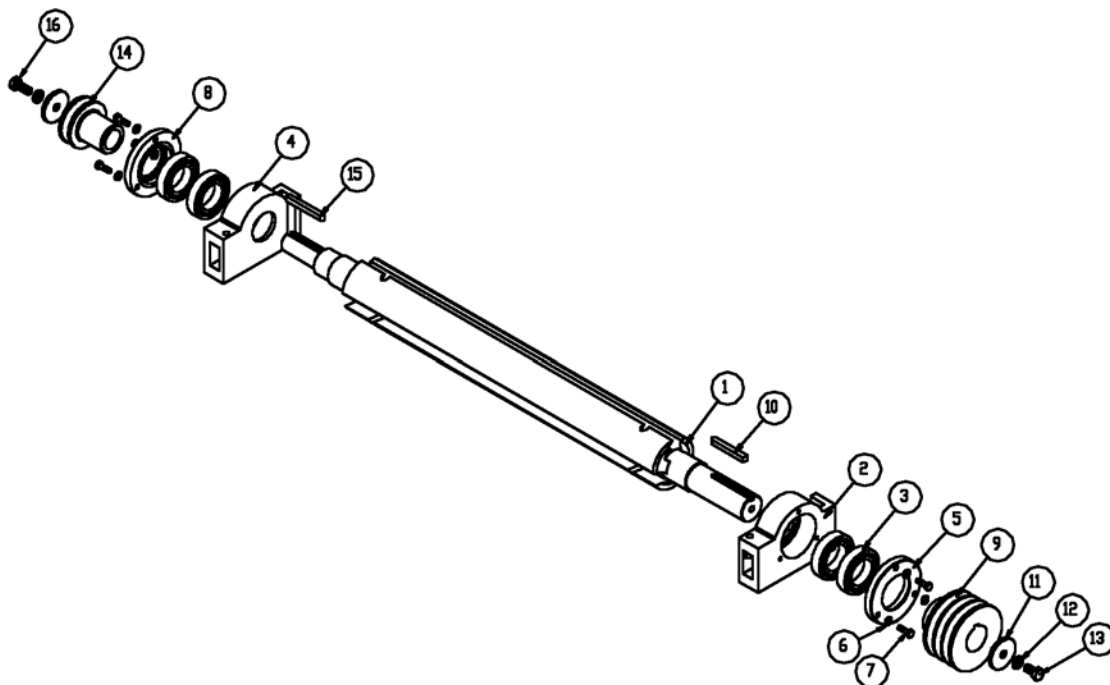


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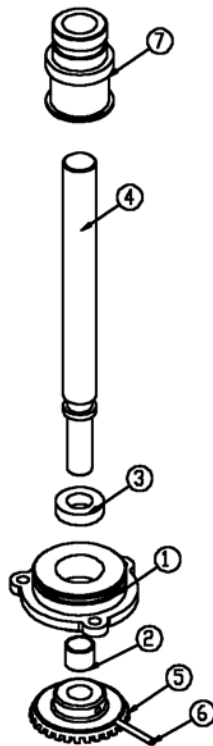
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PARTS LIST **30-460**

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-I01	C011023	CUTTERHEAD		1
30460-I02	C009054	(R) SUPPORT		1
30460-I03	S026048	BEARING	6008ZZ, 40 x 68 x 15	4
30460-I04	C009053	(L) SUPPORT		1
30460-I05	C010026	(R) SUPPORT		1
30460-I06	S284006	LOCK WASHER	6.1 x 12.2 x 2.7 x 1.5T	6
30460-I07	S135003	SCREW	M6-P1.0 X 20L	6
30460-I08	C010028	(L) COVER		1
30460-I09	C064124	PULLEY		1
30460-I10	S003179	KEY	8 x 8 x 65L	1
30460-I11	C053003	WASHER	48 x 11 x 5.0T	2
30460-I12	S284008	SPRING WASHER	10.2 x 12.2 x 3.7 x 2.5T	2
30460-I13	S137021	SCREW	M10-P1.5 x 20L	1
30460-I14	C064128	PULLEY		1
30460-I15	S003180	KEY	8 x 8 x 70L	1
30460-I16	S137004	SCREW	M10-P1.5 x 25L	1

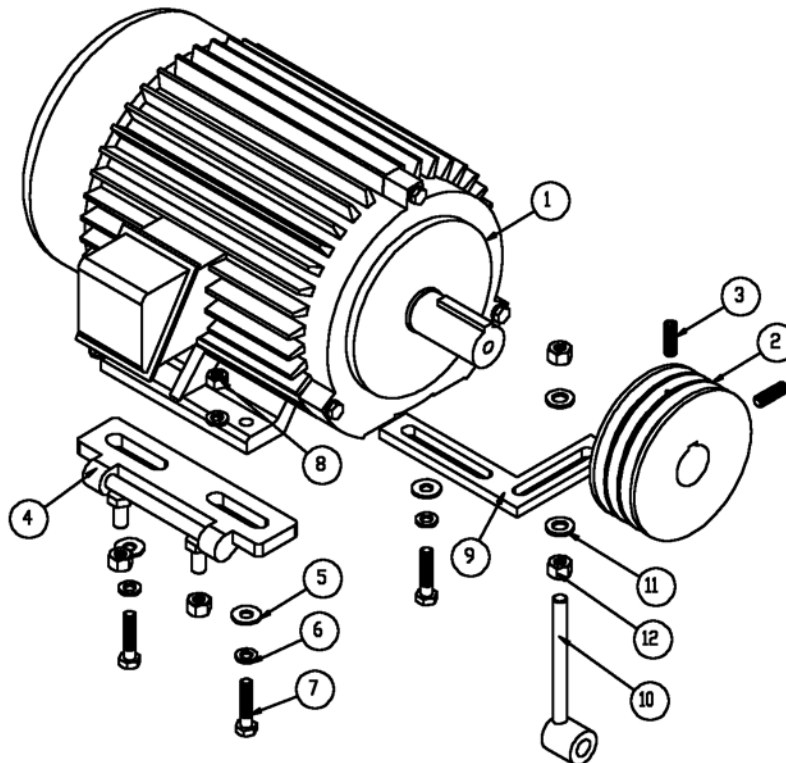


PARTS LIST

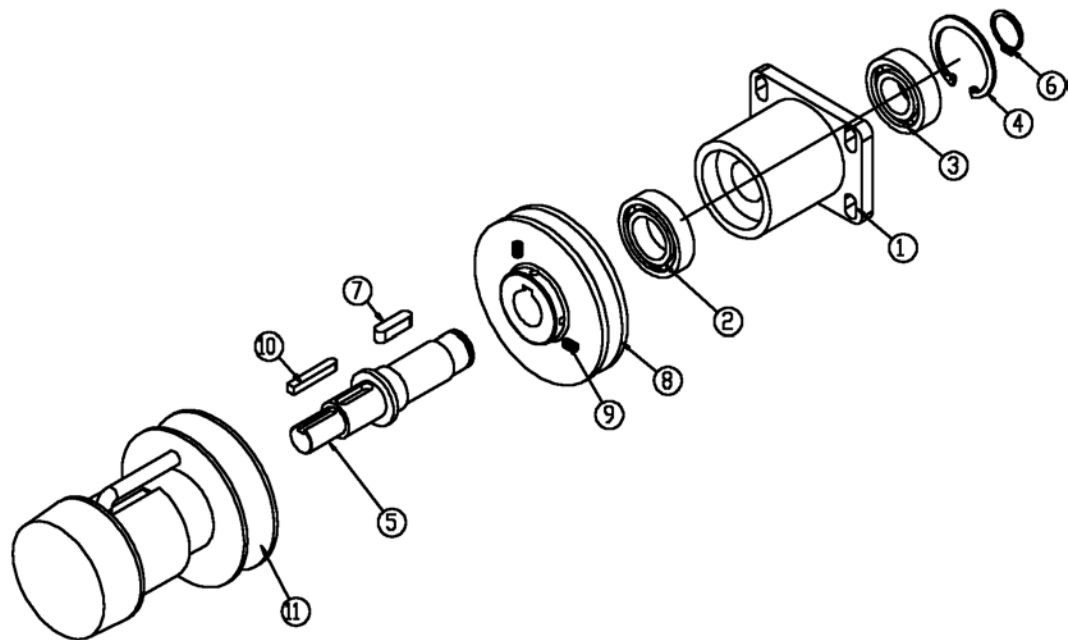
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PARTS LIST 30-460

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-K01	P041008	MOTOR	3HP 1PH	1
30460-K02	C064125	MOTOR PULLEY		1
30460-K03	S214006	SET SCREW	M10-P1.5 x 30L	2
30460-K04	C063003	MOTOR BRACKET		1
30460-K05	S282011	WASHER	10.5 x 25 x 2T	3
30460-K06	S284008	SPRING WASHER	10.2 x 18.4 x 3.7 x 2.5T	6
30460-K07	S137019	SCREW	M10-P1.5 x 45L	6
30460-K08	S273042	NUT	M10-P1.5	6
30460-K09	C049001	BRACKET		1
30460-K10	C034030	ADJ.SCREW		1
30460-K11	S282012	WASHER	13 x 21 x 2.5T	2
30460-K12	S273043	NUT	M12-P1.75	4

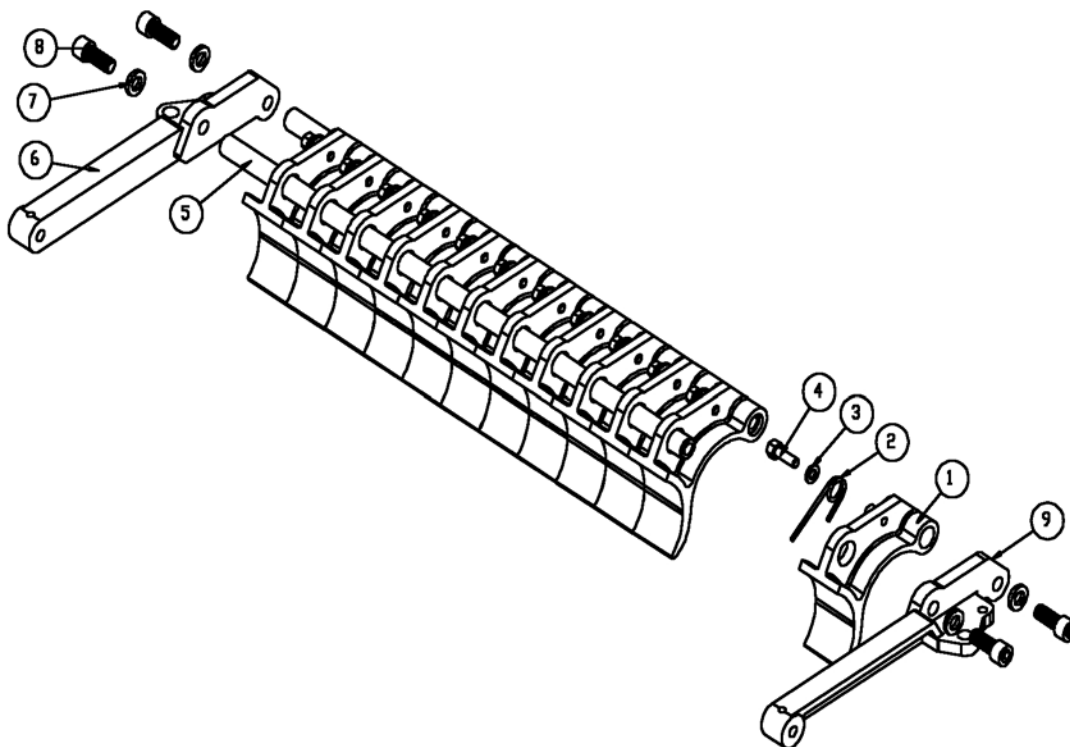


PARTS LIST

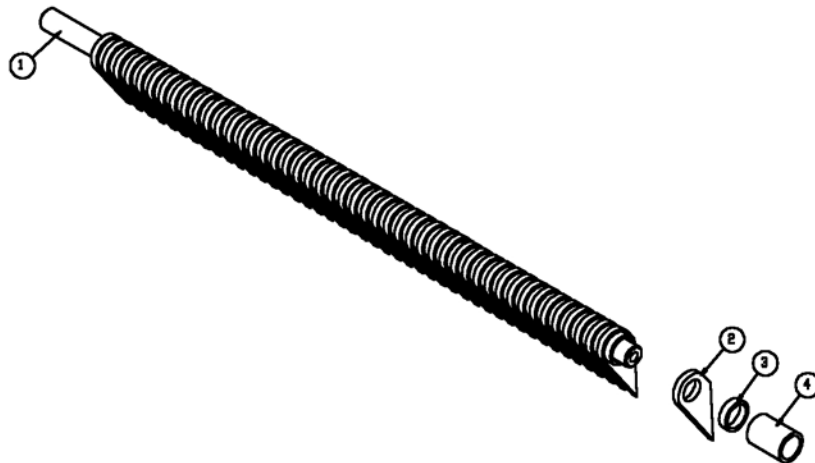
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PARTS LIST **30-460**

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-M01	C042009	CHIP BREAKER		12
30460-M02	C060008	SPRING		12
30460-M03	S282010	SPRING WASHER	8.4 x 15.5 x 1.6T	12
30460-M04	S136004	SCREW	M8-p1.25 x 25L	12
30460-M05	C048037	SHAFT		2
30460-M06	C015095	SUPPORT (L)		1
30460-M07	S284009	SPRING	12.2 x 21.5 x 4.2 x 3.0T	4
30460-M08	S204004	SCREW	M12-P1.75 x 30L	4
30460-M09	C015031	SUPPORT (R)		1

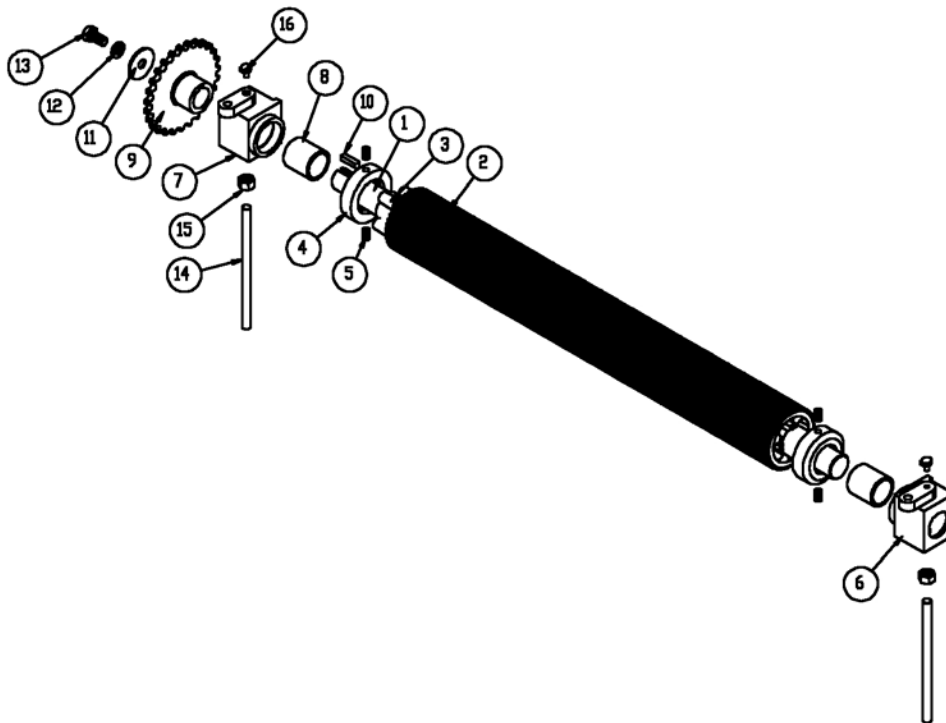


PARTS LIST

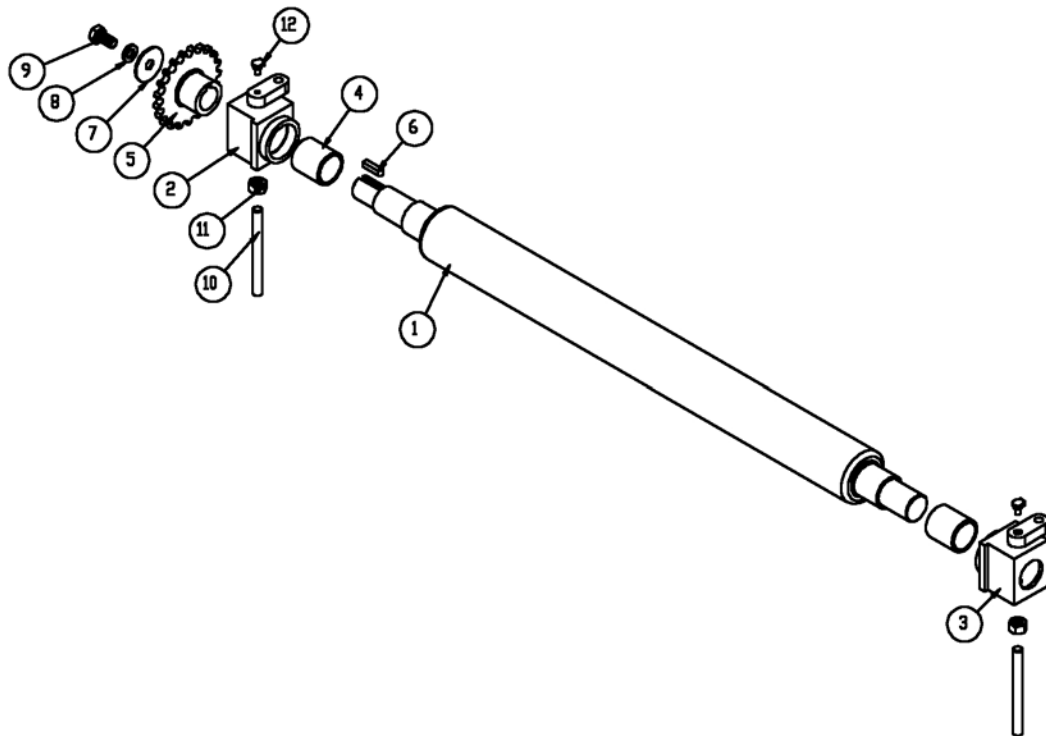
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PARTS LIST 30-460

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-O01	C039027	INFEED SHAFT		1
30460-O02	C038006	INFEED ROLL		24
30460-O03	S318021	RUBBER BUSHING		96
30460-O04	C051023	BUSHING		2
30460-O05	S213001	SET SCREW	M8-P1.25 x 12L	4
30460-O06	C009017	BEARING BLOCK (R)		1
30460-O07	C009049	BEARING BLOCK (L)		1
30460-O08	P051002	BEARING	30 x 36 x 38L	2
30460-O09	C067014	SPROCKET		1
30460-O10	S003073	KEY	6 x 6 x 25L	1
30460-O11	S282049	WASHER	11 x 38 x 2T	1
30460-O12	S284008	SPRING WASHER	10.2 x 18.4 x 3.7 x 2.5T	1
30460-O13	S137021	SCREW	M10-P1.5 x 20L	1
30460-O14	C034022	STUD (165mm)	M10-P1.5 x 165L	2
30460-O15	S273042	NUT	M10-P1.5	2
30460-O16	S319012	OIL CAP		2

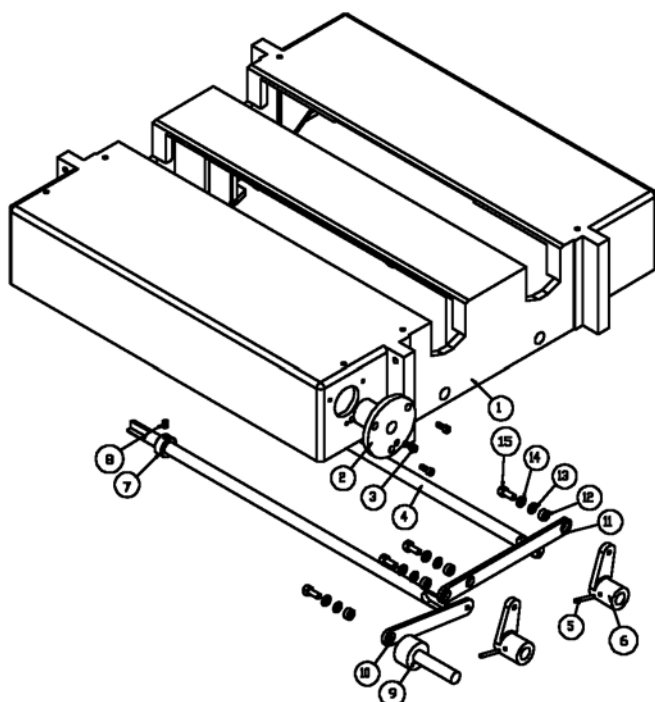


PARTS LIST

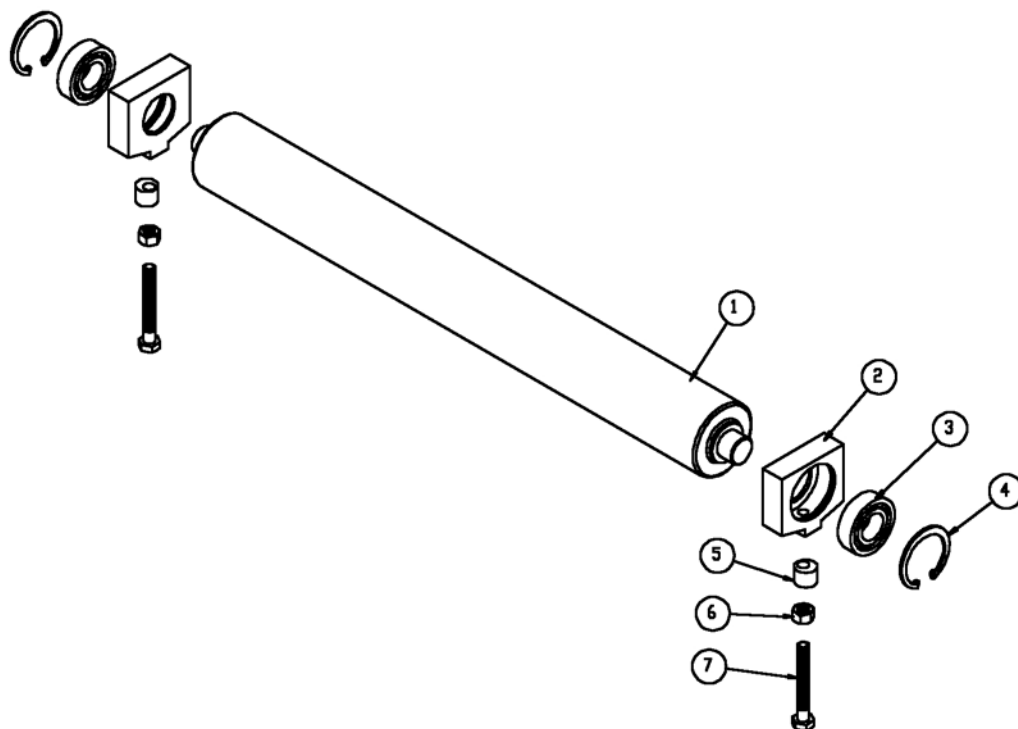
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PARTS LIST 30-460

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-Q01	C006054	TABLE	M6-P1.0 x 16L	1
30460-Q02	C015018	SUPPORT		1
30460-Q03	S201004	SCREW		3
30460-Q04	C017013	ROD		2
30460-Q05	C046076	SPRING PIN	5 x 40L	2
30460-Q06	S267168	ARM		2
30460-Q07	C051008	BUSHING		2
30460-Q08	S213015	SET SCREW	M8-P1.25 x 8L	2
30460-Q09	C046010	SHAFT		1
30460-Q10	C049011	LINK SHORT		1
30460-Q11	C049010	LINK LONG		1
30460-Q12	C051022	ADAPTER		4
30460-Q13	S282010	WASHER	8.4 x 15.5 x 1.6T	4
30460-Q14	S284014	SPRING, WASHER	8.5 x 15.6 x 3.3 x 2.5T	4
30460-Q15	S136003	SCREW	M8-P1.25 x 20L	4

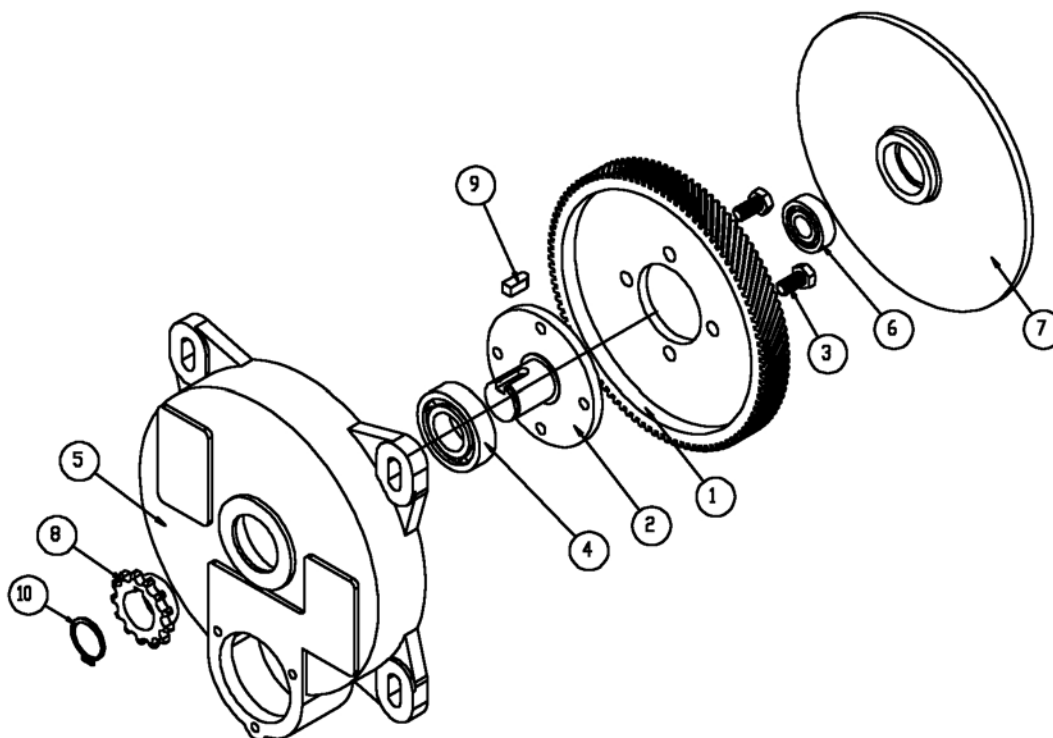


PARTS LIST

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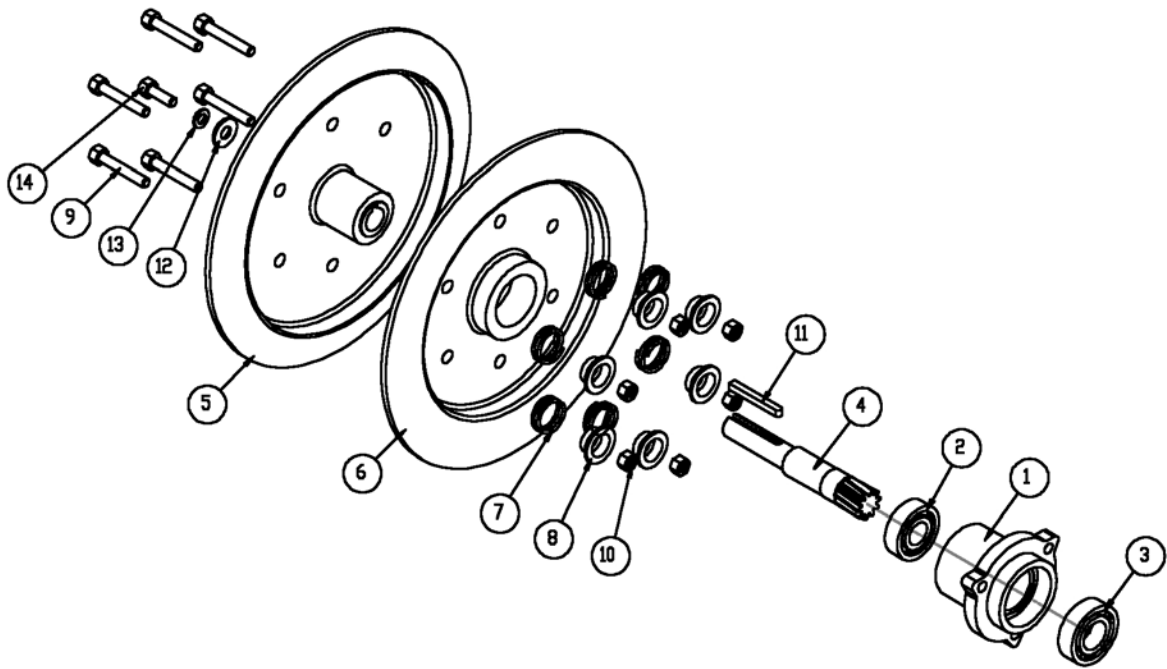
PARTS LIST 30-460

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-S01	C029003	GEAR		1
30460-S02	C039003	GEAR SHAFT		1
30460-S03	S137003	SCREW 10x206cm	M10-P1.5 X20L	4
30460-S04	S026135	BALL BEARING	6206ZZ 30x62x16	1
30460-S05	C031001	GEAR HOUSING		1
30460-S06	S026126	BALL BEARING	6203ZZ 17x40x12	1
30460-S07	C009022	GEAR HOUSING PLATE		1
30460-S08	C067016	SPROCKET		1
30460-S09	S003169	KEY	8 x 8 x 20L	1
30460-S10	S298019	RETAINING RING	30 x 1.75	1



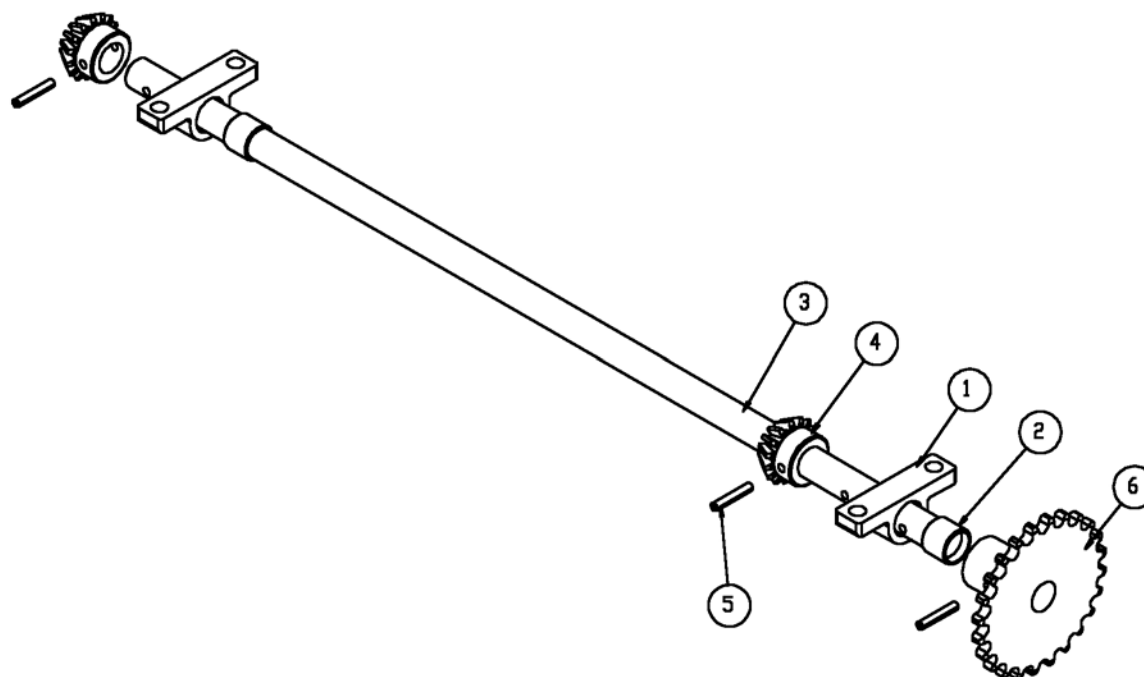
PARTS LIST 30-460

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-T01	C009005	HOUSING		1
30460-T02	S026129	BALL BEARING	6204ZZ 20 x 47 x 14	1
30460-T03	S026132	BALL BEARING	6205ZZ 25 x 52 x 15	1
30460-T04	C0029007	PINION GEAR		1
30460-T05	C064017	PULLEY		1
30460-T06	C064016	PULLEY		1
30460-T07	C060020	SPRING		6
30460-T08	C051013	COLLAR		6
30460-T09	S136006	SCREW	M8-P1.25 X 50L	6
30460-T10	S273041	NUT	M8-P1.25	6
30460-T11	S00380	KEY	6 x 6 x 55L	1
30460-T12	S282011	WASHER	10.5 x 25 x 2.0T	1
30460-T13	S284007	SPRING WASHER	8.2 x 15.4 x 3.2 x 2.0T	1
30460-T14	S136004	SCREW	M8-P1.25 x 25L	1

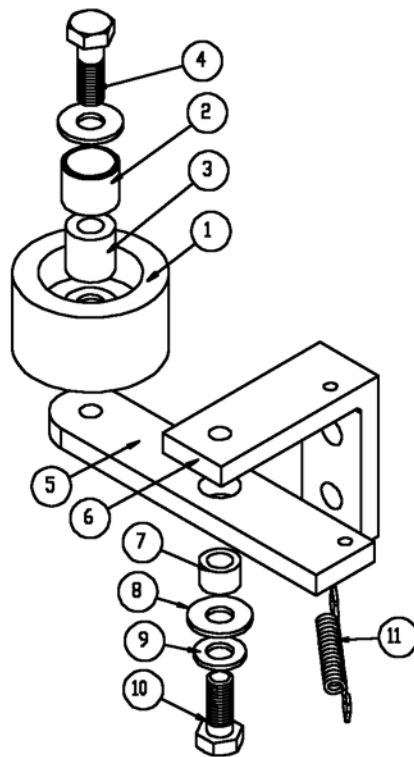


PARTS LIST

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-U01	C015015	SUPPORT		2
30460-U02	P051001	BEARING	19.05 x 22.2	2
30460-U03	C039026	SHAFT	19.05 x 662L	1
30460-U04	C028002	GEAR		2
30460-U05	S267166	PIN	5 x 30L	3
30460-U06	C067018	SPROCKET		1

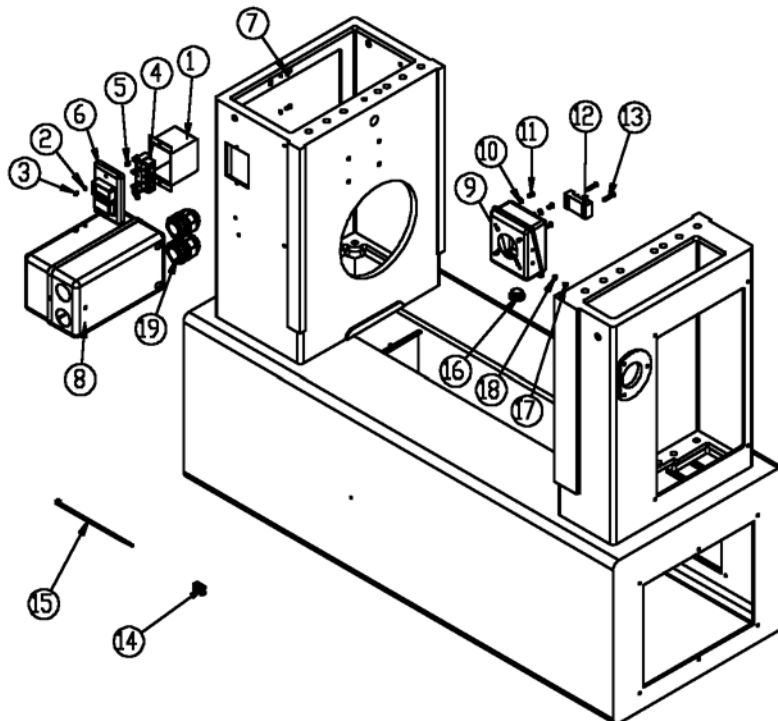


PARTS LIST

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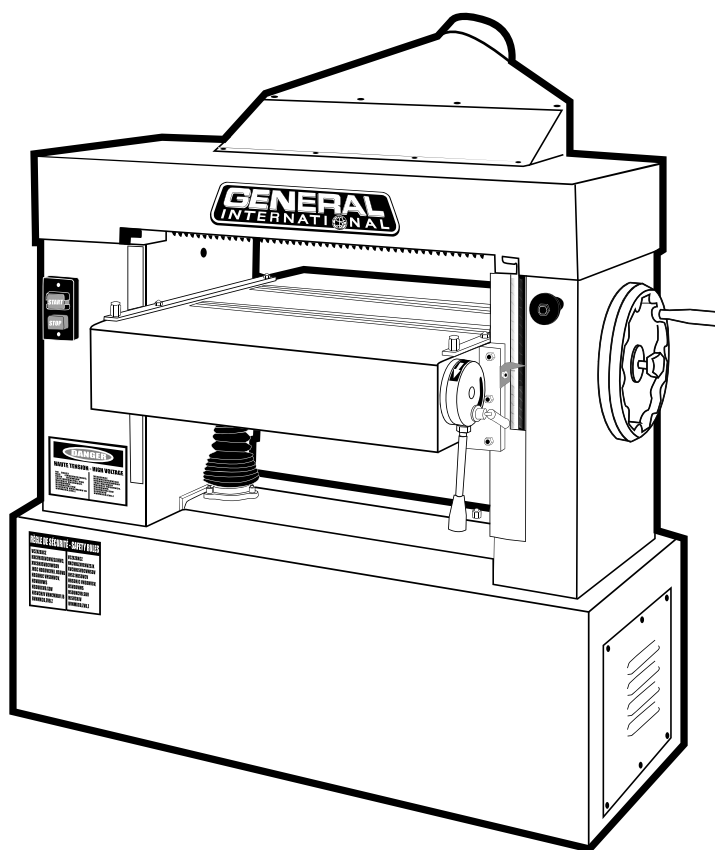
PARTS LIST **30-460**

PART NO.	REFERENCE NO.	DESCRIPTION	SPECIFICATION	QTY
30460-W01	C085001	SWITCH BOX		1
30460-W02	S284020	SPRING WASHER	4.1 x 7 x 1.7 x 1.0T	4
30460-W03	S224101	RD HD SCREW	5/32» - 32NC x 6L	2
30460-W04	S3114011	SWITCH		1
30460-W05	S273100	SPACER	5/32» - 32NC	2
30460-W06	S314012	SWITCH COVER		1
30460-W07	S224102	SCREW	5/32» - 32NC x 12L	2
30460-W08	S311008	MAGNETIC SWITCH		1
30460-W09	S312003	JUNCTION BOX		1
30460-W10	S282008	WASHER	5.3 x 10 x 1.0T	4
30460-W11	S225002	SCREW	M5-P0.8 x 10L	8
30460-W12	S313001	TERMINAL STRIP	30A	1
30460-W13	S225006	SCREW	M5-P0.8 x 20L	2
30460-W14	S328001	TIE MOUNTS	20 x 20 x 2	3
30460-W15	S329003	CABLE TIE	2.5 x 150L	5
30460-W16	S317023	BUSHING		3
30460-W17	S224001	SCREW	M4-P0.7 x 6L	1
30460-W18	S283004	TEETH WASHER		3
30460-W19	S317012	STRAIN RELIEF CLAMP		3



NOTES

30-460



**8360, Champ-d'Eau, Montreal (Quebec)
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IMPORTANT: When ordering replacement parts, always give the model number, serial number of the machine and part number. Also a brief description of each item and quantity desired.